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MARK	DESIGNATION	MODIF.A	MODIF.B	MODIF.C
45	FREE			
46	FREE			
47	8 PLC AO R0/S5 CH0-CH3	8/13/1991	6/24/2003	
48	8 PLC AO R0/S5 CH4-CH7			
49	8 PLC AO R0/S6 CH0-CH3			
50	8 PLC AO R0/S6 CH4-CH7			
51	RACK TSX_RCE_860			
52	8 PLC AO R0/S7 CH0-CH3	8/13/1991		
53	8 PLC AO R0/S7 CH4-CH7	8/13/1991		
54	8 PLC AO R0/S8 CH0-CH3	8/13/1991		
55	8 PLC AO R0/S8 CH4-CH7	8/13/1991		
56	8 PLC AO R0/S9 CH0-CH3	8/13/1991		
57	8 PLC AO R0/S9 CH4-CH7			
58	8 PLC AO R0/S10 CH0-CH3			
59	FREE			
60	FREE			
61	FREE			
62	FREE			
63	RACK TSX_RCE_860			
64	32 PLC DI R0/S11 CH0-CH7			
65	32 PLC DI R0/S11 CH8-CH15			
66	32 PLC DI R0/S11 CH16-CH23			
67	32 PLC DI R0/S11 CH24-CH31			
68	32 PLC DI R0/S12 CH0-CH7			
69	32 PLC DI R0/S12 CH8-CH15			
70	32 PLC DI R0/S12 CH16-CH23			
71	32 PLC DI R0/S12 CH24-CH31			
72	32 PLC DI R1/S0 CH0-CH7			
73	32 PLC DI R1/S0 CH8-CH15			
74	32 PLC DI R1/S0 CH16-CH23			
75	32 PLC DI R1/S0 CH24-CH31			
76	32 PLC DI R1/S1 CH0-CH7			
77	32 PLC DI R1/S1 CH8-CH15			
78	32 PLC DI R1/S1 CH16-CH23	6/24/1993		
79	32 PLC DI R1/S1 CH24-CH31			
80	32 PLC DI R1/S2 CH0-CH7	6/24/1993		
81	32 PLC DI R1/S2 CH8-CH15	6/24/1993		
82	32 PLC DI R1/S2 CH16-CH23	6/24/1993		
83	32 PLC DI R1/S2 CH24-CH31	6/24/1993		
84	32 PLC DI R1/S3 CH0-CH7			
85	32 PLC DI R1/S3 CH8-CH15	6/24/1993		
86	32 PLC DI R1/S3 CH16-CH23	6/24/1993		
87	32 PLC DI R1/S3 CH24-CH31	6/24/1993		
88	32 PLC DI R1/S4 CH0-CH7	8/13/1991		
89	32 PLC DI R1/S4 CH8-CH15			
90	32 PLC DI R1/S4 CH16-CH23			

Line1 F13 Reterry

	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.		
	DRAWN BY	Leo Lin	
CHECKED BY			

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	01-22-2025	SCALE	UNIT	MM

Page #	1
KF F13	Total

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MARK	DESIGNATION	MODIF.A	MODIF.B	MODIF.C
91	32 PLC DI R1/S4 CH24-CH31			
92	32 PLC DI R1/S5 CH0-CH7			
93	32 PLC DI R1/S5 CH8-CH15			
94	32 PLC DI R1/S5 CH16-CH23			
95	32 PLC DI R1/S5 CH24-CH31			
96	RACK TSX_RCE_860			
97	32 PLC DI R1/S6 CH0-CH7			
98	32 PLC DI R1/S6 CH8-CH15	8/13/1991		
99	32 PLC DI R1/S6 CH16-CH23			
100	32 PLC DI R1/S6 CH24-CH31			
101	32 PLC DI R1/S7 CH0-CH7			
102	32 PLC DI R1/S7 CH8-CH15			
103	32 PLC DI R1/S7 CH16-CH23			
104	32 PLC DI R1/S7 CH24-CH31	8/13/1991		
105	32 PLC DI R1/S8 CH0-CH7			
106	32 PLC DI R1/S8 CH8-CH15			
107	32 PLC DI R1/S8 CH16-CH23		6/24/1993	
108	32 PLC DI R1/S8 CH24-CH31		6/24/1993	
109	32 PLC DI R1/S9 CH0-CH7	8/13/1991		
110	32 PLC DI R1/S9 CH8-CH15	8/13/1991		
111	32 PLC DI R1/S9 CH16-CH23	8/13/1991		
112	32 PLC DI R1/S9 CH24-CH31	8/13/1991		
113	32 PLC DI R1/S10 CH0-CH7	8/13/1991		
114	32 PLC DI R1/S10 CH8-CH15		6/24/1993	
115	32 PLC DI R1/S10 CH16-CH23			
116	32 PLC DI R1/S10 CH24-CH31		6/24/1993	
117	32 PLC DI R1/S11 CH0-CH7			
118	32 PLC DI R1/S11 CH8-CH15			
119	32 PLC DI R1/S11 CH16-CH23		6/24/1993	
120	32 PLC DI R1/S11 CH24-CH31		6/24/1993	
121	FREE			
122	FREE			
123	FREE			
124	FREE			
125	32 PLC DI R2/S0 CH0-CH7			
126	32 PLC DI R2/S0 CH8-CH15		6/24/1993	
127	32 PLC DI R2/S0 CH16-CH23	8/13/1991	6/24/1993	
128	32 PLC DI R2/S0 CH24-CH31	8/13/1991		
129	RACK TSX_RCE_860			
130	FREE			
131	FREE			
132	FREE			
133	FREE			
134	FREE			
135	FREE			
136	FREE			

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	DRAWN NO.	DRAWING NO.	DRAWING DESCRIPTION	KF F13	Page #	Page #
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				01-22-2025						
DRAWN BY	Leo Lin									
CHECKED BY										

Line1 F13 Reterry

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MARK	DESIGNATION	MODIF.A	MODIF.B	MODIF.C
137	FREE			
138	FREE			
139	FREE			
140	FREE			
141	FREE			
142	FREE			
143	FREE			
144	FREE			
145	FREE			
146	32 PLC DI R2/S1 CH0-CH7	8/13/1991		
147	32 PLC DI R2/S1 CH8-CH15	8/13/1991		
148	32 PLC DI R2/S1 CH16-CH23			
149	32 PLC DI R2/S1 CH24-CH31	8/13/1991		
150	32 PLC DI R2/S2 CH0-CH7			
151	32 PLC DI R2/S2 CH8-CH15			
152	32 PLC DI R2/S2 CH16-CH23			
153	32 PLC DI R2/S2 CH24-CH31			
154	32 PLC DI R2/S3 CH0-CH7			
155	32 PLC DI R2/S3 CH8-CH15			
156	32 PLC DI R2/S3 CH16-CH23			
157	32 PLC DI R2/S3 CH24-CH31			
158	32 PLC DI R2/S4 CH0-CH7			
159	32 PLC DI R2/S4 CH8-CH15			
160	32 PLC DI R2/S4 CH16-CH23		6/24/1993	
161	32 PLC DI R2/S4 CH24-CH31			
162	RACK TSX_RCE_860	8/13/1991		
163	32 PLC DI R2/S5 CH0-CH7		6/24/1993	
164	32 PLC DI R2/S5 CH8-CH15		6/24/1993	
165	32 PLC DI R2/S5 CH16-CH23	8/13/1991	6/24/1993	
166	32 PLC DI R2/S5 CH24-CH31			
167	32 PLC DI R2/S6 CH0-CH7	8/13/1991	6/24/1993	
168	32 PLC DI R2/S6 CH8-CH15			
169	32 PLC DI R2/S6 CH16-CH23			
170	32 PLC DI R2/S6 CH24-CH31			
171	32 PLC DI R2/S7 CH0-CH7			
172	32 PLC DI R2/S7 CH8-CH15			
173	32 PLC DI R2/S7 CH16-CH23		6/24/1993	
174	32 PLC DI R2/S7 CH24-CH31			
175	32 PLC DI R2/S8 CH0-CH7		6/24/1993	
176	32 PLC DI R2/S8 CH8-CH15			
177	32 PLC DI R2/S8 CH16-CH23	8/13/1991	6/24/1993	
178	32 PLC DI R2/S8 CH24-CH31	8/13/1991		
179	32 PLC DI R2/S9 CH0-CH7	8/13/1991		
180	32 PLC DI R2/S9 CH8-CH15	8/13/1991		
181	32 PLC DI R2/S9 CH16-CH23	8/13/1991		
182	32 PLC DI R2/S9 CH24-CH31	8/13/1991		

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MARK	DESIGNATION	MODIF.A	MODIF.B	MODIF.C
183	32 PLC DI R2/S10 CH0-CH7	8/13/1991		
184	32 PLC DI R2/S10 CH8-CH15			
185	32 PLC DI R2/S10 CH16-CH23		6/24/1993	
186	32 PLC DI R2/S10 CH24-CH31			
187	32 PLC DI R2/S11 CH0-CH7			
188	32 PLC DI R2/S11 CH8-CH15		6/24/1993	
189	32 PLC DI R2/S11 CH16-CH23	8/13/1991	6/24/1993	
190	32 PLC DI R2/S11 CH24-CH31	8/13/1991	10/29/1991	6/24/1993
191	FREE			
192	FREE			
193	FREE			
194	FREE			
200	WATER BATH LEVEL L5L 1050-03			
210	TERMINAL BOLCKS X13 1 - 32			
211	TERMINAL BOLCKS X13 33 - 64			
212	TERMINAL BOLCKS X13 65 - 96			
213	TERMINAL BOLCKS X13 97 - 128			
214	TERMINAL BOLCKS X13 129 - 160			
215	TERMINAL BOLCKS X13 161 - 192		6/24/1993	
216	TERMINAL BOLCKS X13 193 - 224		6/24/1993	
217	TERMINAL BOLCKS X13 225 - 256			
218	TERMINAL BOLCKS X13 257 - 288		6/24/1993	
219	TERMINAL BOLCKS X13 289 - 320			
220	TERMINAL BOLCKS X13 321 - 352			
221	TERMINAL BOLCKS X13 353 - 384			
222	TERMINAL BOLCKS X13 385 - 416		6/24/1993	
223	TERMINAL BOLCKS X13 417 - 448			
224	TERMINAL BOLCKS X13 449 - 480			
225	TERMINAL BOLCKS X13 481 - 512	8/13/1991	6/24/1993	
226	TERMINAL BOLCKS X13 513 - 544		6/24/1993	
227	TERMINAL BOLCKS X13 545 - 576			
228	TERMINAL BOLCKS X13 577 - 608			
229	TERMINAL BOLCKS X13 609 - 640			
230	TERMINAL BOLCKS X13 641 - 672			
231	TERMINAL BOLCKS X13 673- 704			
232	TERMINAL BOLCKS X13 705 - 736		6/24/1993	
233	TERMINAL BOLCKS X13 737 - 768			
234	TERMINAL BOLCKS X13 769 - 800			
235	TERMINAL BOLCKS X13 801 - 832		6/24/1993	
236	TERMINAL BOLCKS X13 833 - 864		6/24/1993	
237	TERMINAL BOLCKS X13 865 - 896			
238	TERMINAL BOLCKS X13 897 - 928		6/24/1993	
239	TERMINAL BOLCKS X13 929 - 960		6/24/1993	
240	TERMINAL BOLCKS X13 961 - 992		6/24/1993	
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242	TERMINAL BOLCKS X13 1025 - 1056		6/24/1993	

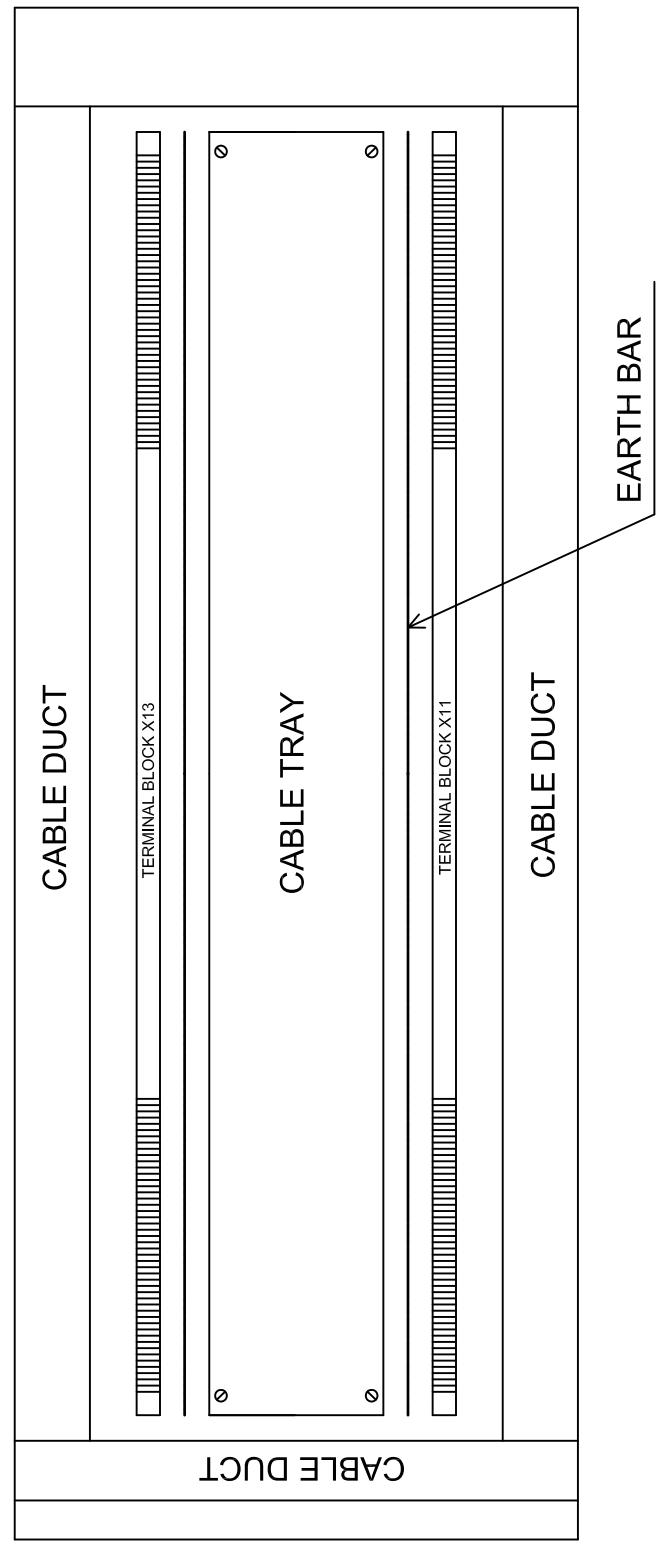
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 INTEPLAST GROUP, Ltd.
 AMTOPP DIV. MIE DEPT.
 DRAWN BY Leo Lin
 CHECKED BY

Line1 F13 Repertory

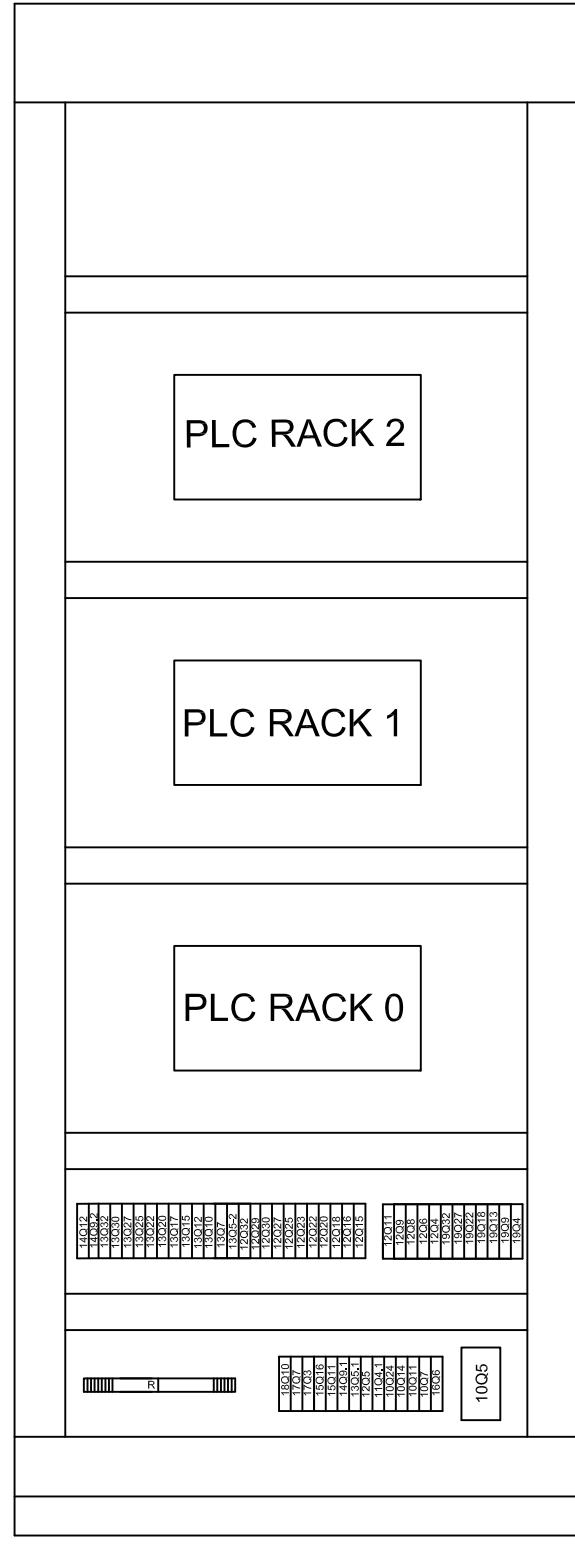
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INTEPLAST GROUP, Ltd. AMTOPP DIVI. ME DEPT.	JEFF LEE	VINCENT HUANG
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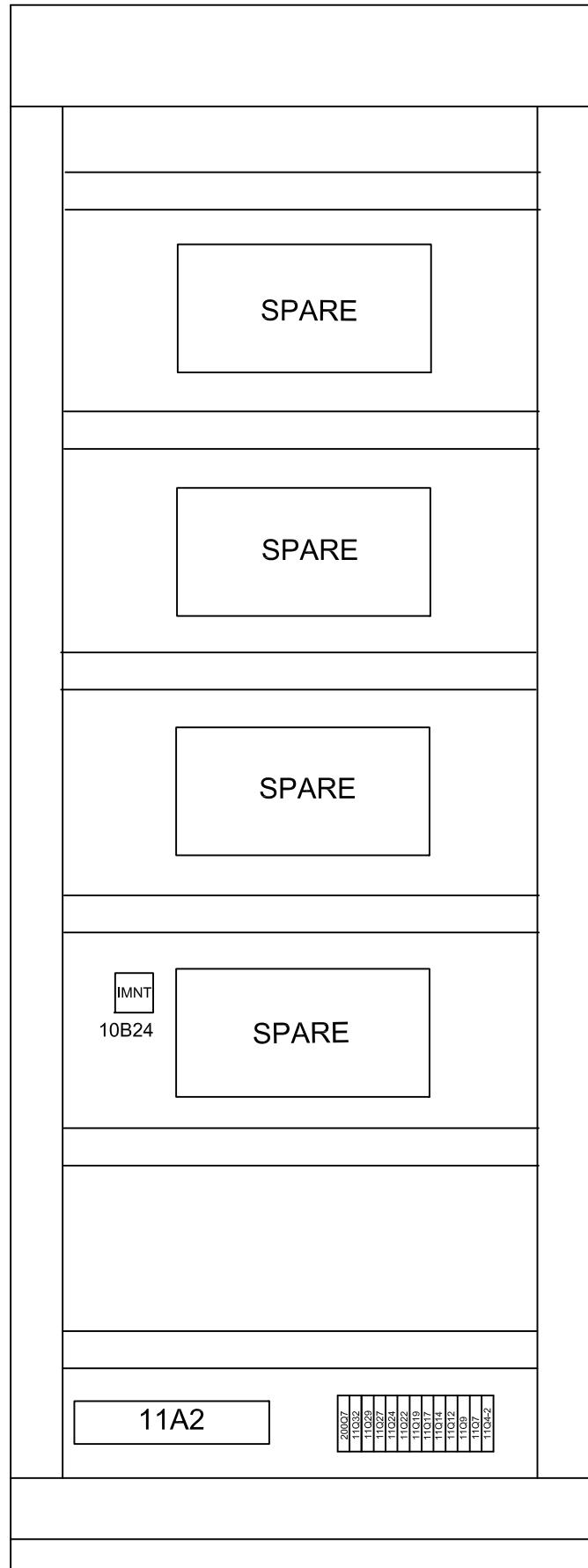


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	INTEPLAST GROUP, Ltd.	AMTOPP DIVI. MIE DEPT.																															
DRAWN BY	Leo Lin																																
CHECKED BY	VINCENT HUANG																																

DOOR 2

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	03-03-2014	SCALE	NONE	UNIT	MM
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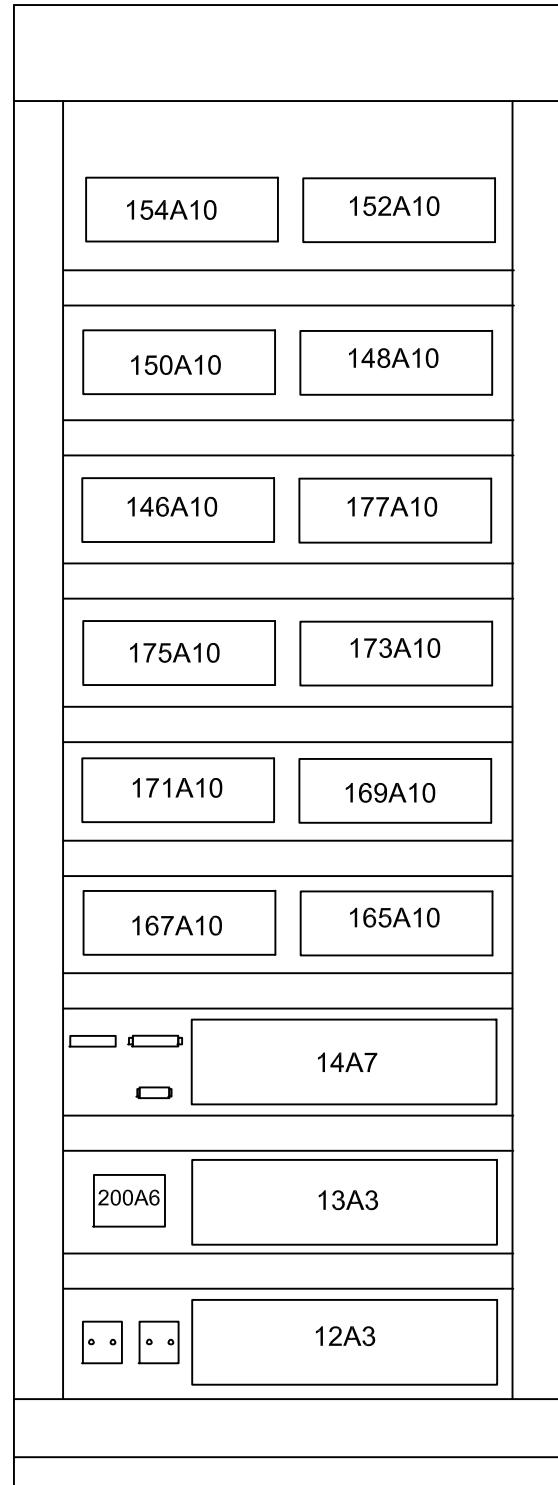
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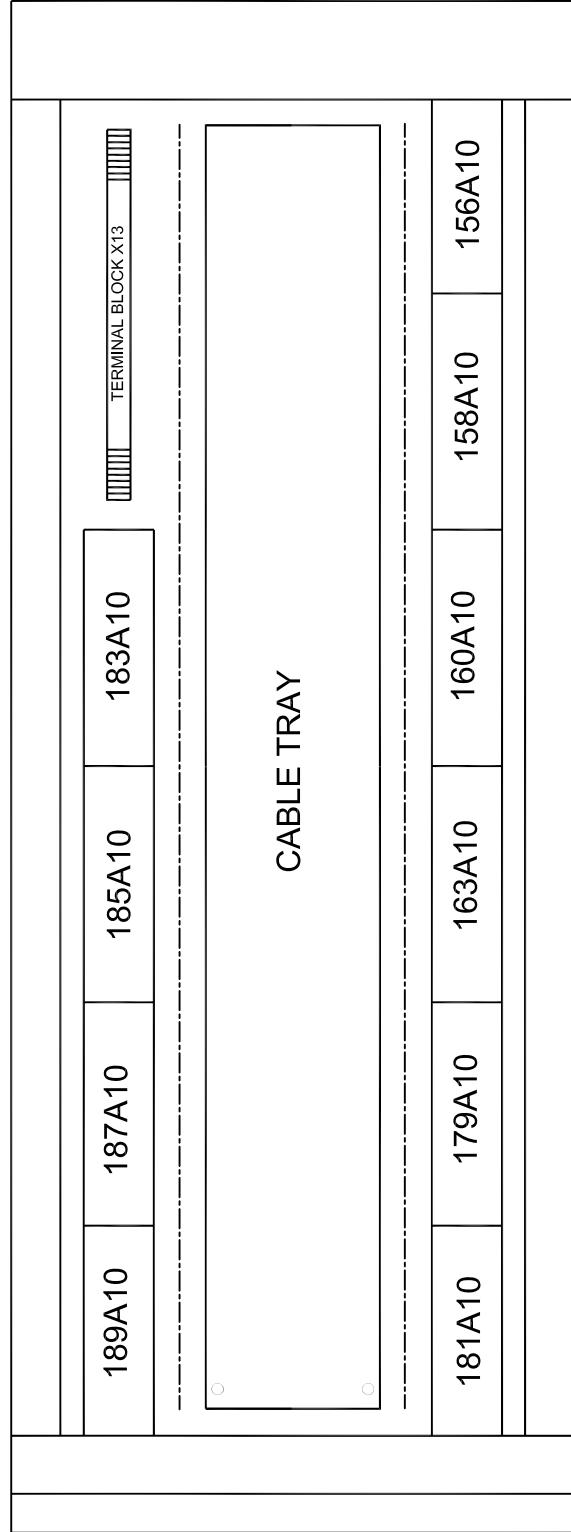
DOOR 3

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DOOR 4

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CHECKED BY	VINCENT HUANG	MATERIAL	MM
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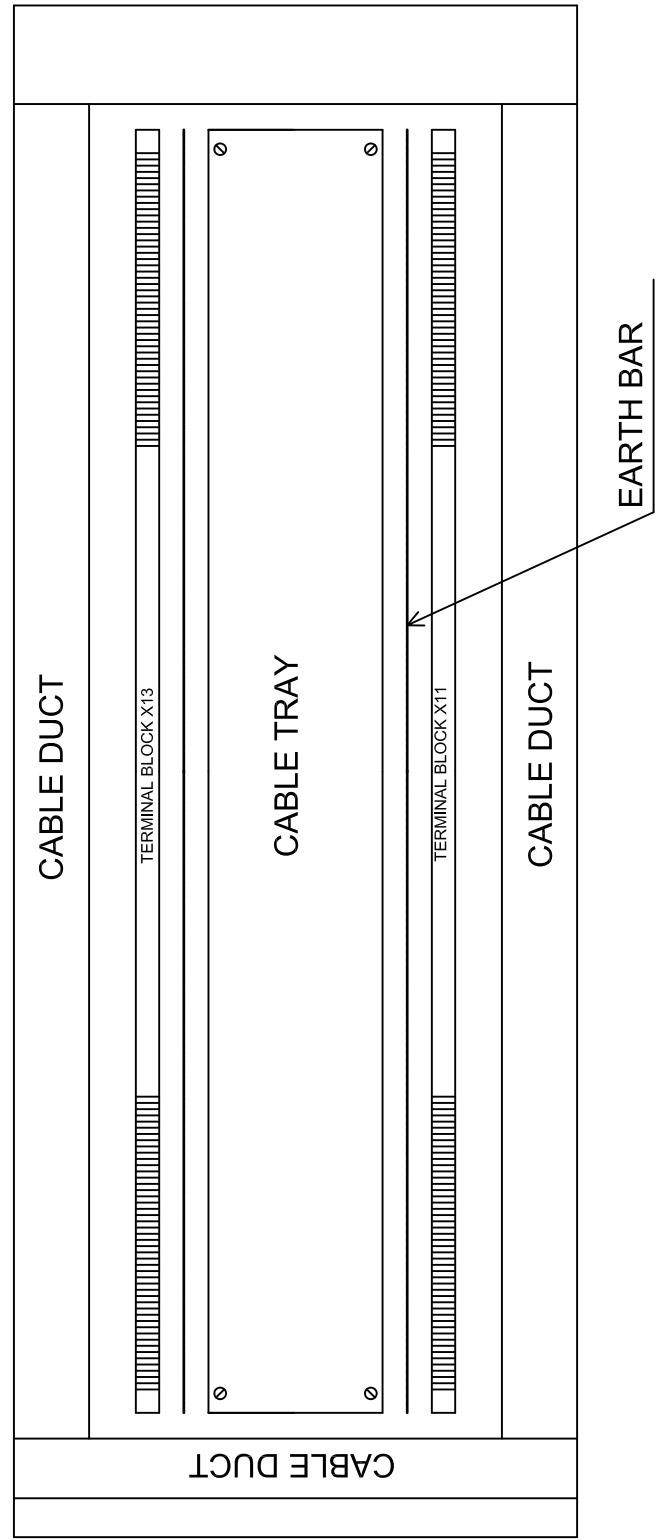
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INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

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01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34



	INTEPLAST GROUP, Ltd. AMTOPP DIVI. MIE DEPT.	DOOR 6	KF F13	Page # 6
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CHECKED BY	VINCENT HUANG	REV. NO	REV. DESCRIPTION	REV. BY: DRAWN DATE: 03-03-2014

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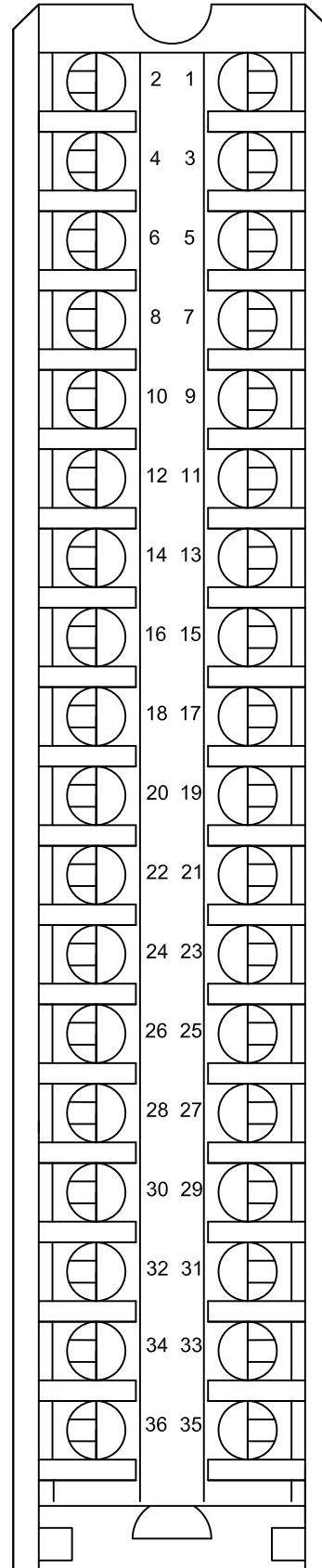
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IN DOOR 6(RIGHT)

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WHT , IN-1
GRN , IN-3
BLU , IN-5
RD/BLK , IN-7
ORG/BLK , IN-9
BLK/WHT , IN-11
GRN/WHT , IN-13
BLK/RD , IN-15
ORG/RD , GND-0
RD/GRN , IN-17
BLK/WHT-RD , IN-19
RD/BLK-WHT , IN-21
ORG/BLK-WHT , IN-23
BLK/RD-GRN , IN-25
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ORG/WHT-BLU , GND-1



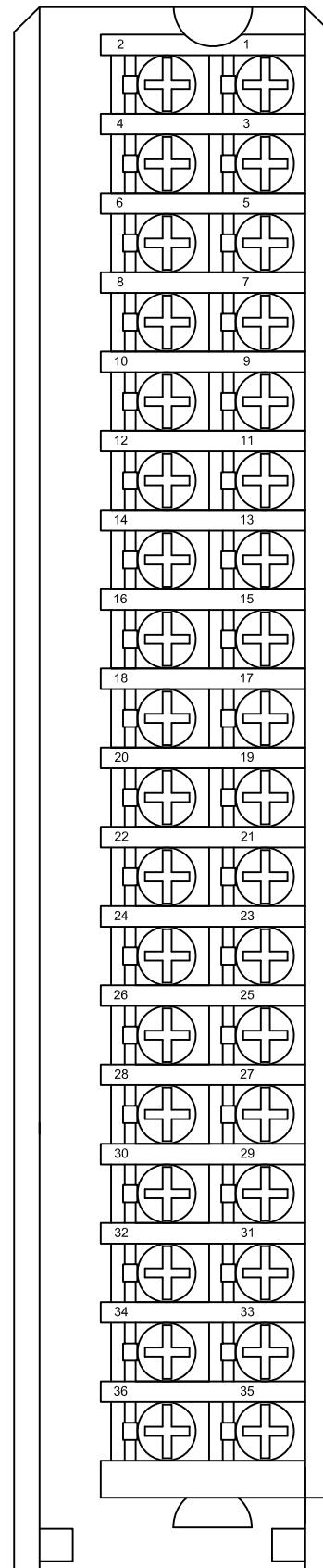
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IN-4 , ORG
IN-6 , WHT/BLK
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IN-14 , BLU/WHT
GND-0 , WHT/RD
IN-16 , BLU/RD
IN-18 , ORG/GRN
IN-20 , WHT/BLK-RD
IN-22 , GRN/BLK-WHT
IN-24 , BLU/BLK-WHT
IN-26 , WHT/RD-GRN
IN-28 , GRN/BLK-ORG
IN-30 , BLU/WHT-ORG
GND-1 , WHT/RD-ORG

1756-IB32 DC INPUT MODULE

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GRN , IN_0/B
BLU , RTN_0/C
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ORG/BLK , IN_2/B
BLK/WHT , RTN_2/C
GRN/WHT , IN_4/A
BLK/RD , IN_4/B
ORG/RD , RTN_4/C
RD/GRN , IN_6/A
BLK/WHT-RD , IN_6/B
RD/BLK-WHT , RTN_6/C
ORG/BLK-WHT , IN_8/A
BLK/RD-GRN , IN_8/B
RD/BLK-GRN , RTN_8/C
ORG/BLK-GRN , IN_10/A
BLK/WHT-ORG , IN_10/B
ORG/WHT-BLU , RTN_10/C



IN_1/A , BLK
IN_1/B , RD
RTN_1/C , ORG
IN_3/A , WHT/BLK
IN_3/B , GRN/BLK
RTN_3/C , BLU/BLK
IN_5/A , RD/WHT
IN_5/B , BLU/WHT
RTN_5/C , WHT/RD
IN_7/A , BLU/RD
IN_7/B , ORG/GRN
RTN_7/C , WHT/BLK-RD
IN_9/A , GRN/BLK-WHT
IN_9/B , BLU/BLK-WHT
RTN_9/C , WHT/RD-GRN
IN_11/A , GRN/BLK-ORG
IN_11/B , BLU/WHT-ORG
RTN_11/C , WHT/RD-ORG

CH0: 2, 4, 6
CH1: 1, 3, 5
CH2: 8, 10, 12
CH3: 7, 9, 11

CH4: 14, 16, 18
CH5: 13, 15, 17
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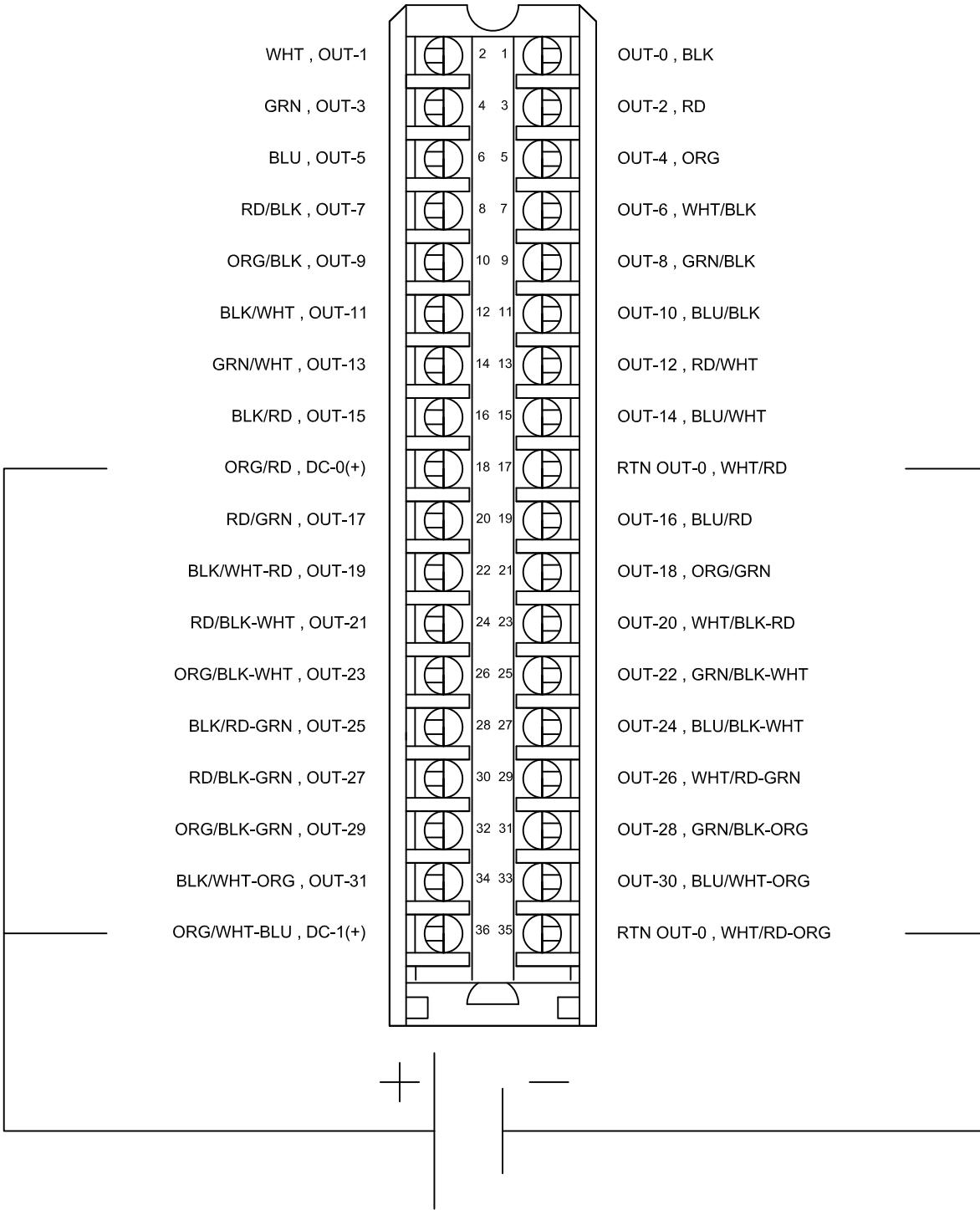
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INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

DRAWN BY: Bryan Hong

CHECKED BY: Jerry Wu



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IOUT-4 , GRN		IOUT-0 , RD
RTN , BLU		RTN , ORG
VOUT-5 , RD/BLK		VOUT-1 , WHT/BLK
IOUT-5 , ORG/BLK		IOUT-1 , GRN/BLK
VOUT-6 , BLK/WHT		VOUT-2 , BLU/BLK
IOUT-6 , GRN/WHT		IOUT-2 , RD/WHT
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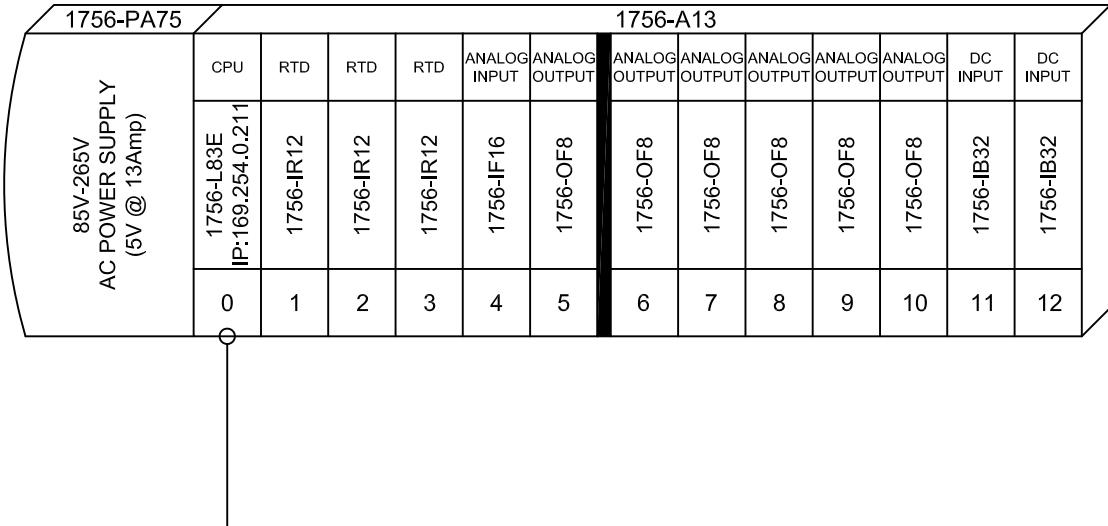
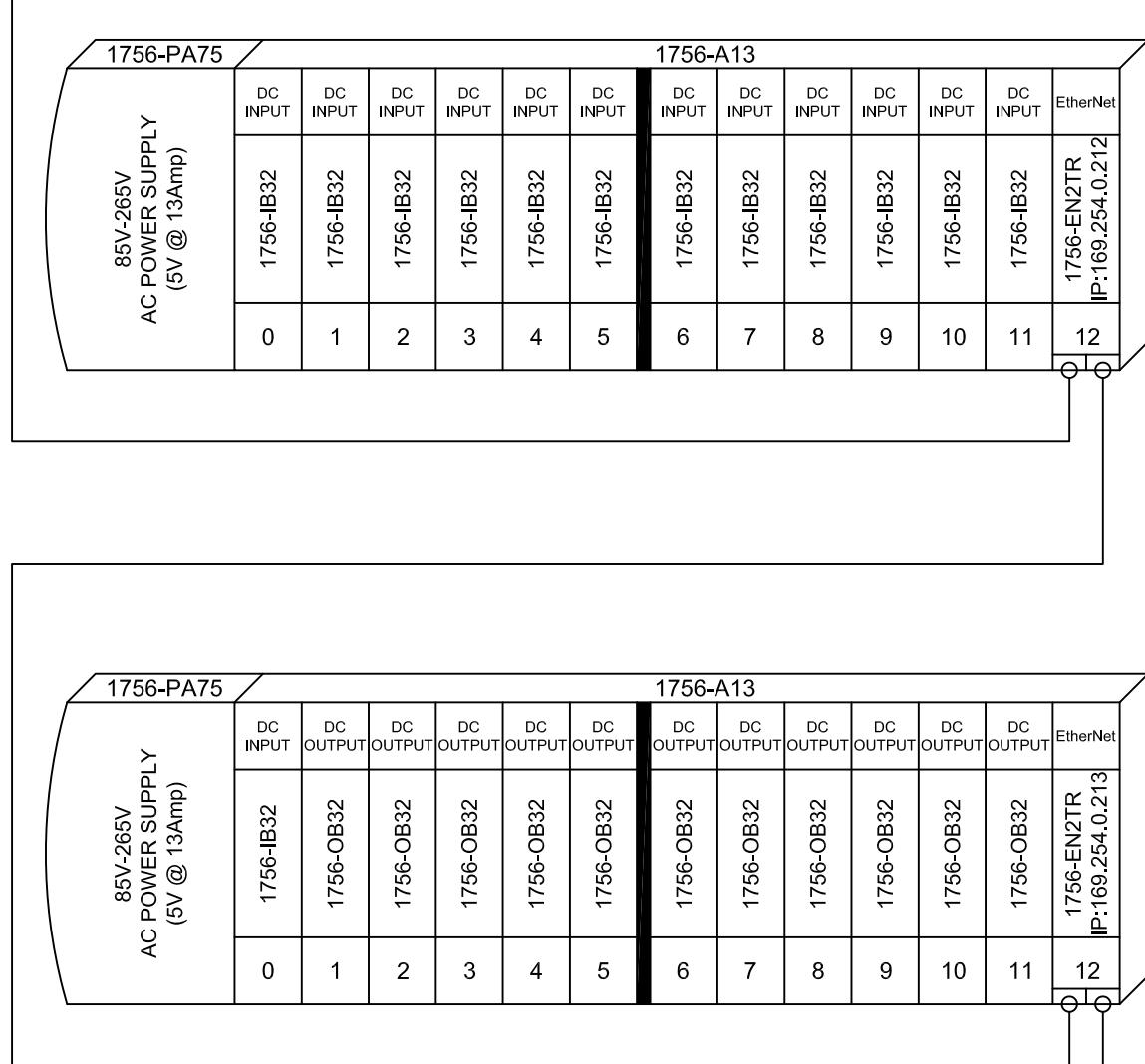
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DRAWN BY	Bryan Hong	CHECKED BY	Jerry Wu							

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RACK 0

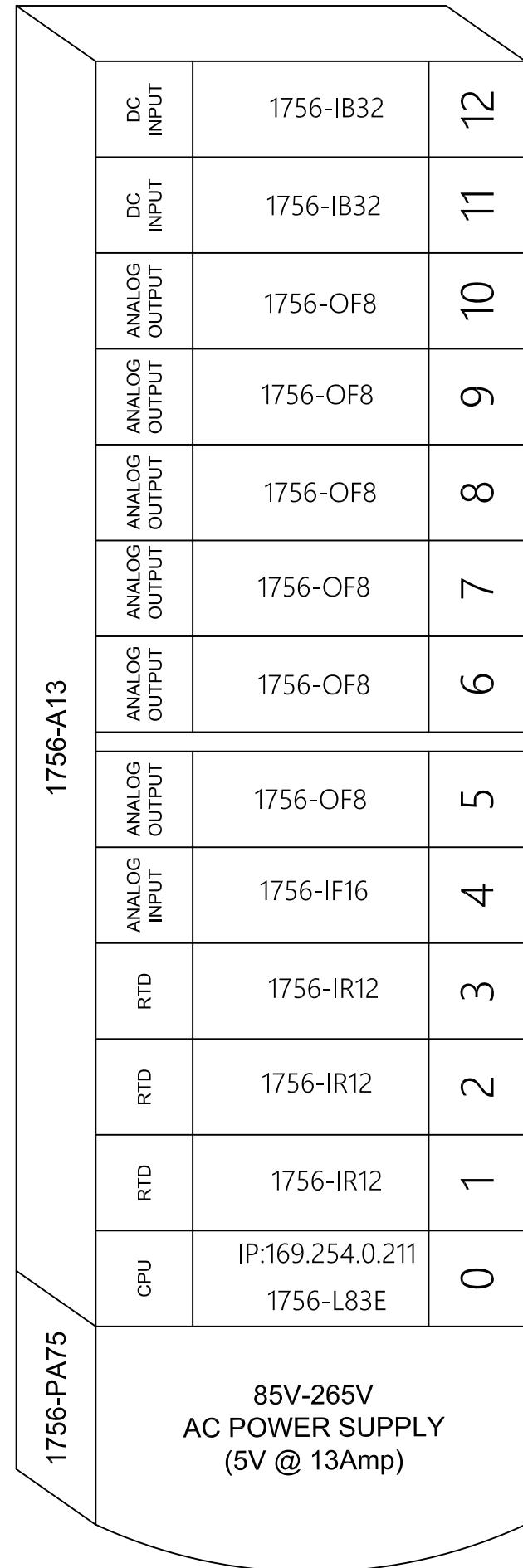
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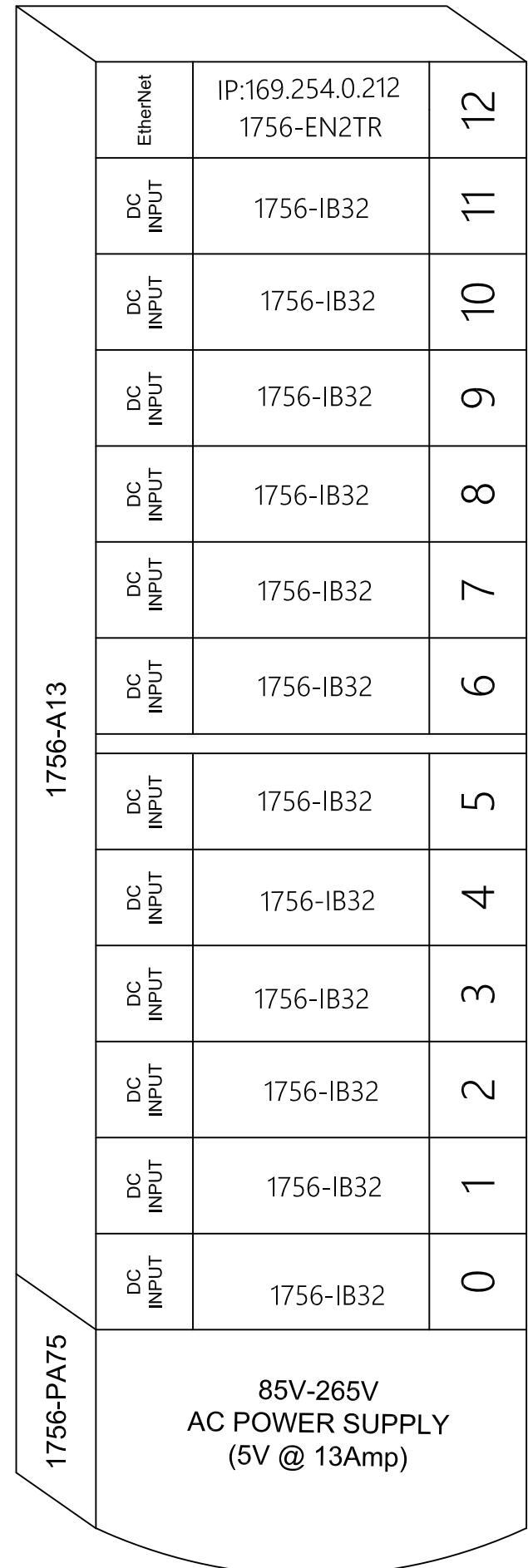
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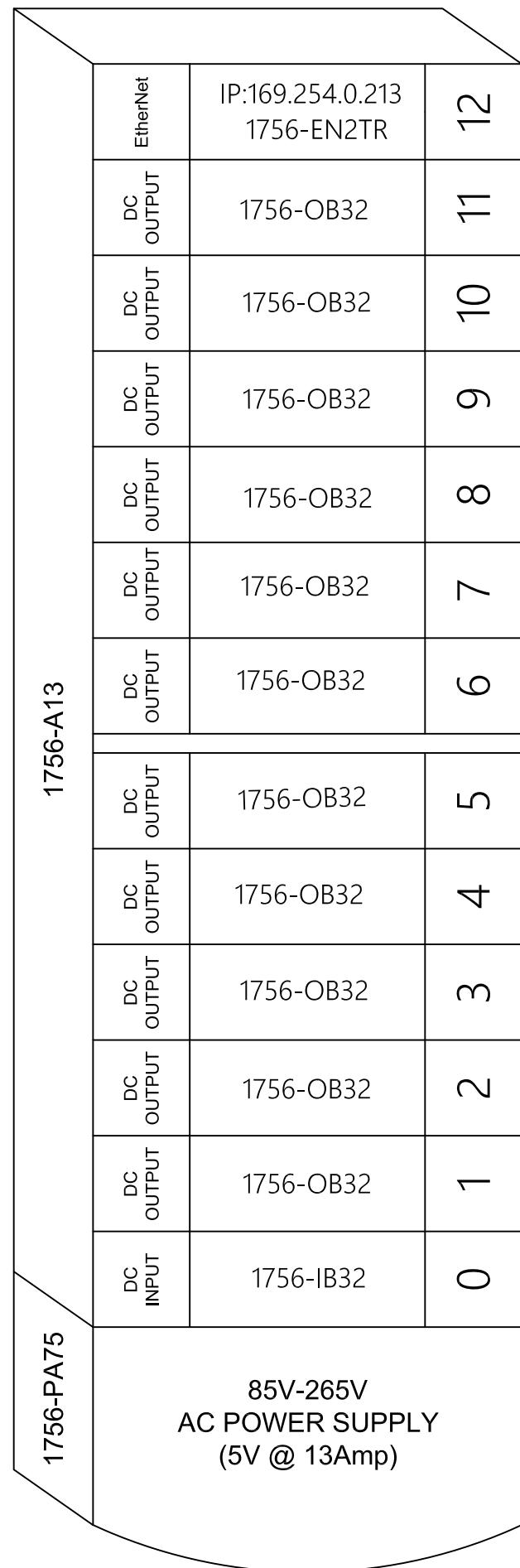


85V-265V
AC POWER SUPPLY
(5V @ 13Amp)

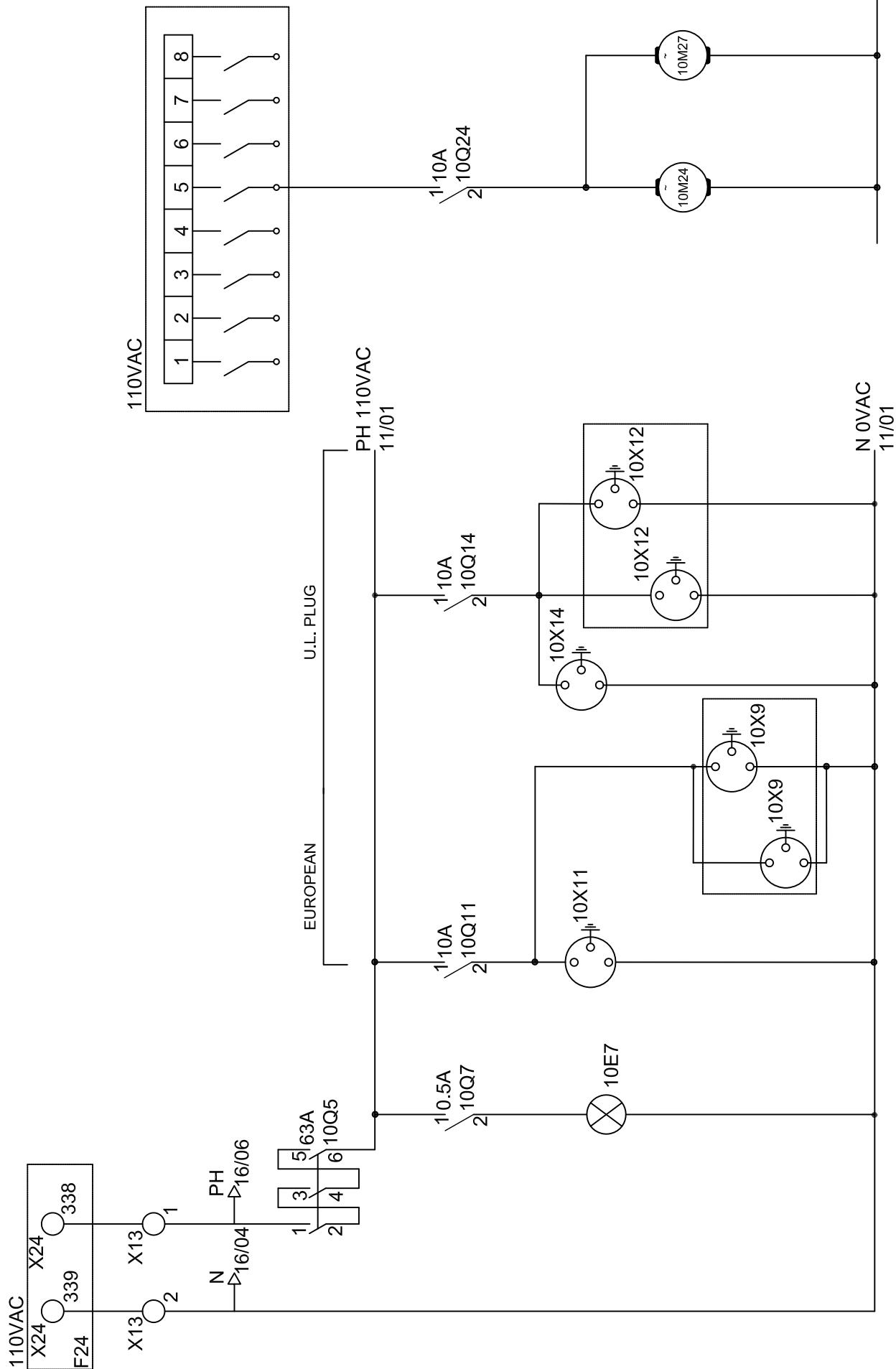
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Line1_F13
Allen Bradley PLC F





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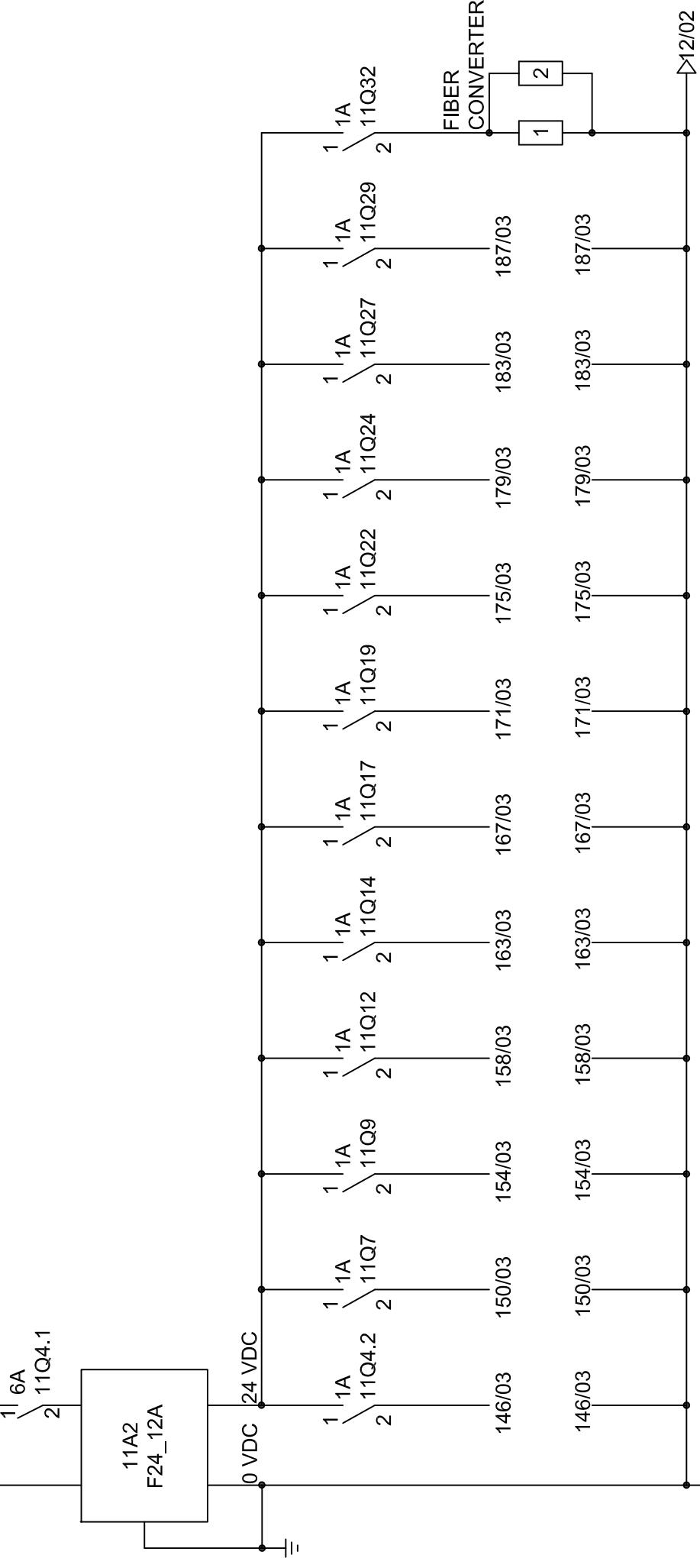
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 INTEPLAST GROUP, Ltd. AMTOPP DIVI. M/E DEPT.	
DRAWN BY	Bryan Hong
CHECKED BY	Vincent Huang

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10/31

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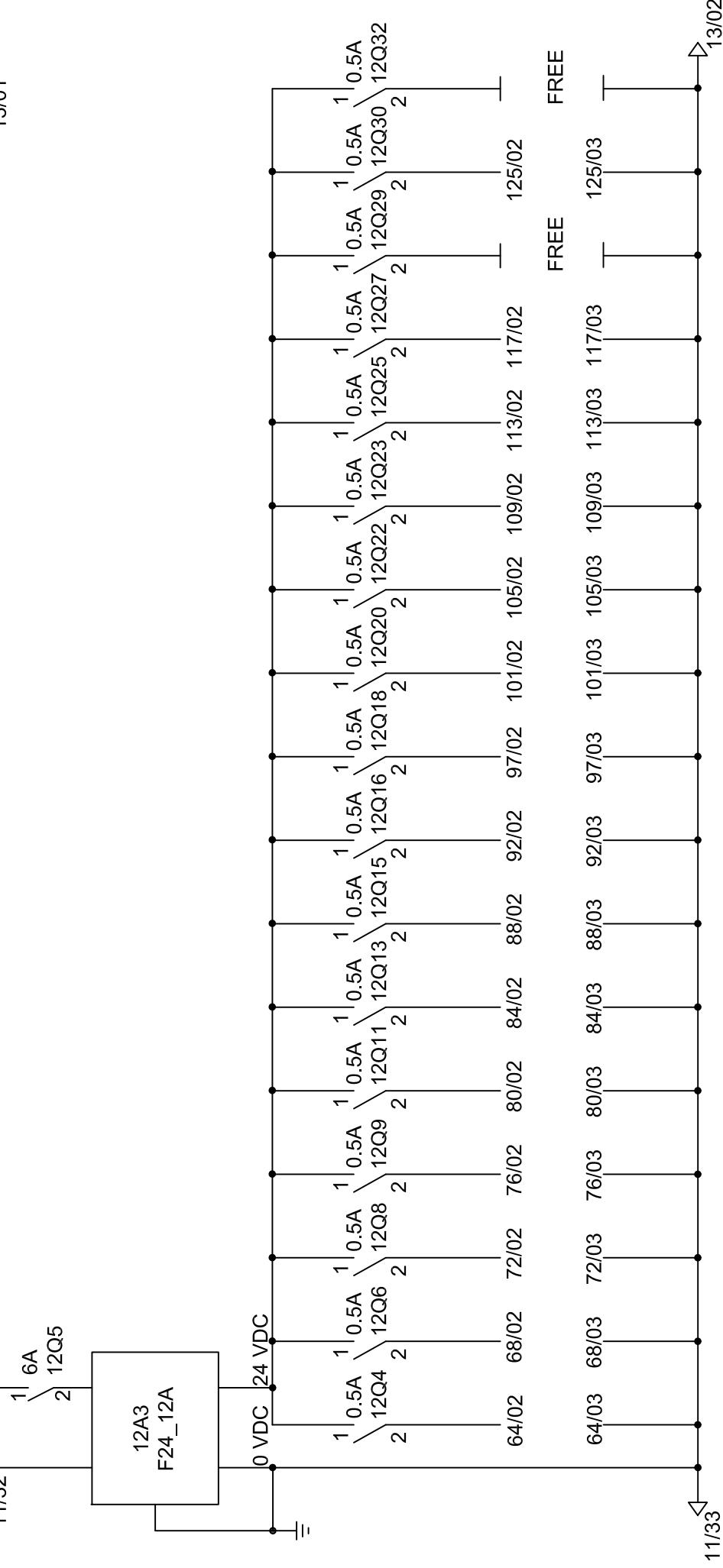


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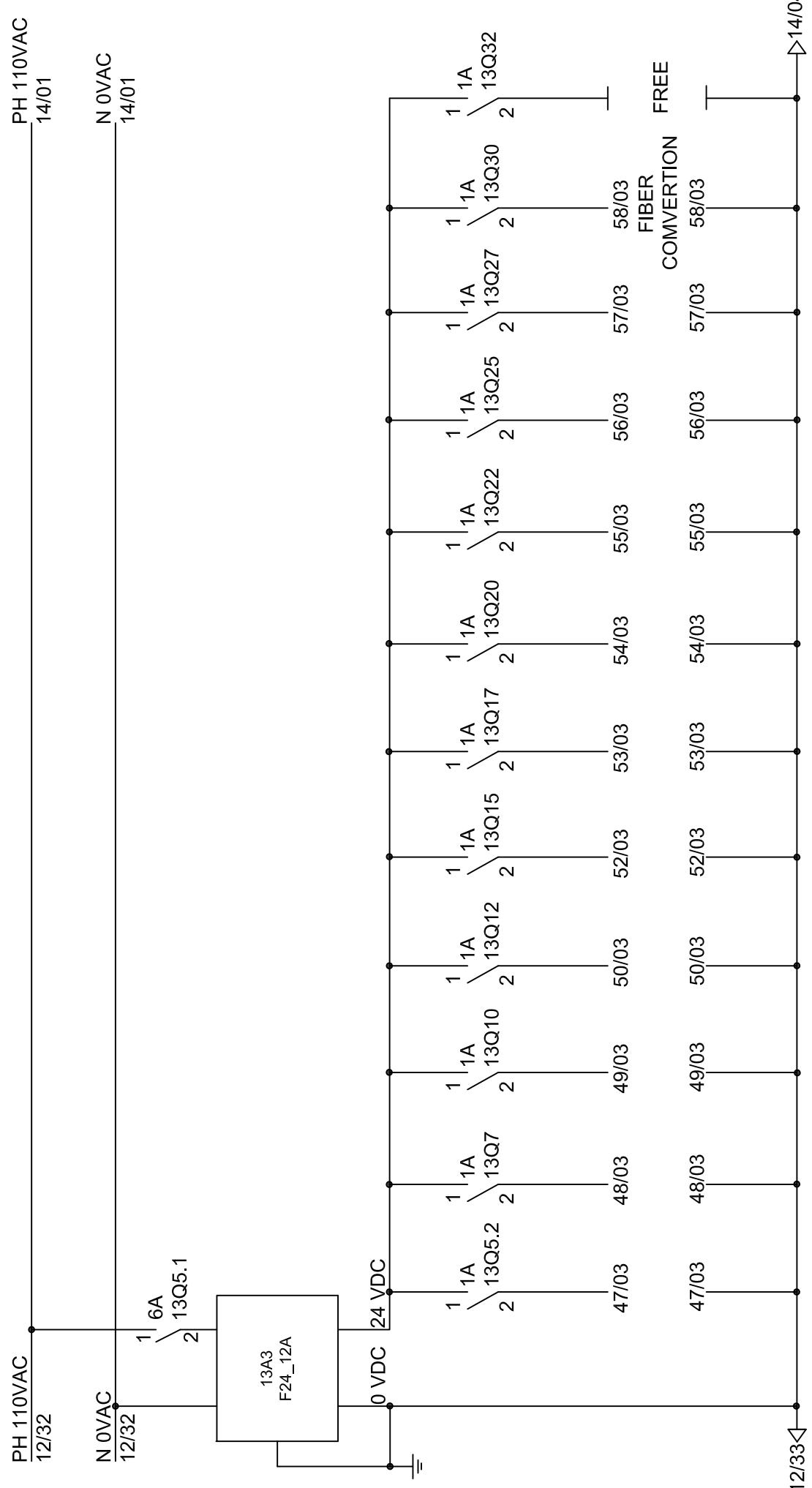
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DIGITAL INBRIEFING

 INTEPLAST GROUP, Ltd. AMTOPP DIVI. ME DEPT.	DRAWN BY JEFF LEE	CHECKED BY VINCENT HUANG
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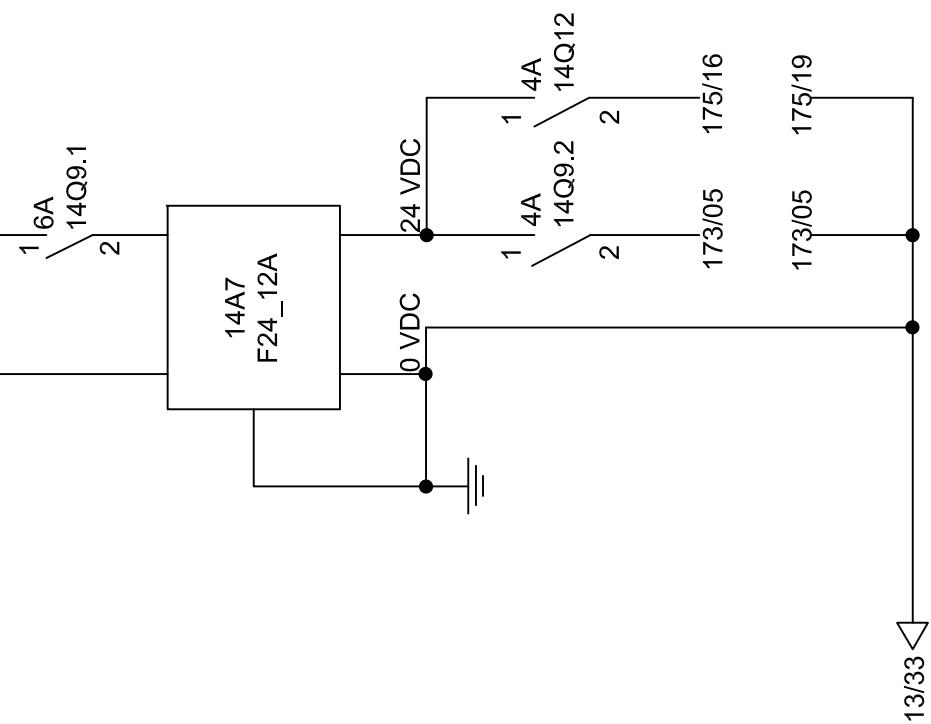
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13/32
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13/32

PH 110VAC
15/01

N 0VAC
15/01



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INTEPLAST GROUP, Ltd.
AMTOPP DIVI. MIE DEPT.

DRAWN BY JEFF LEE

CHECKED BY VINCENT HUANG

LIGHT SUPPLY

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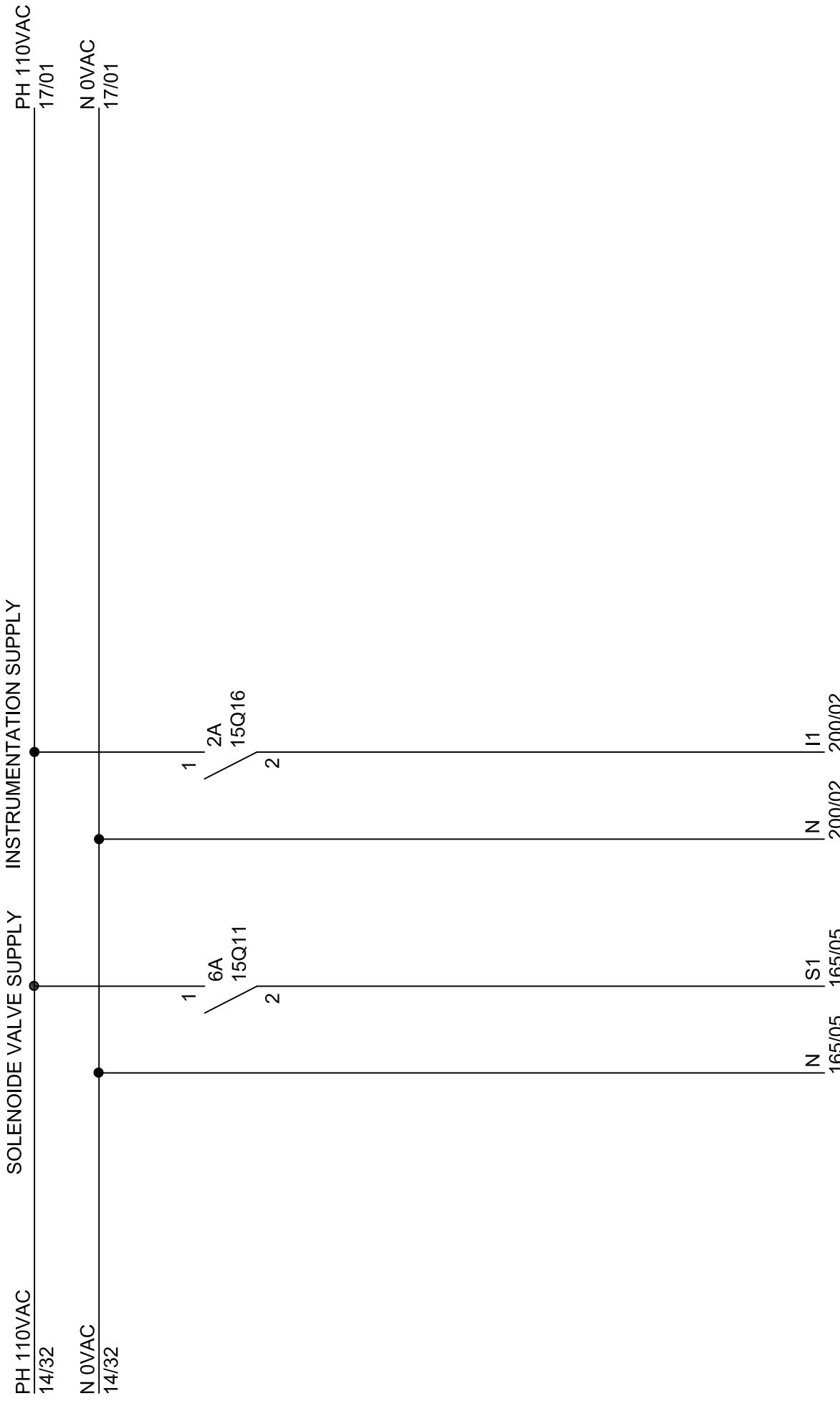
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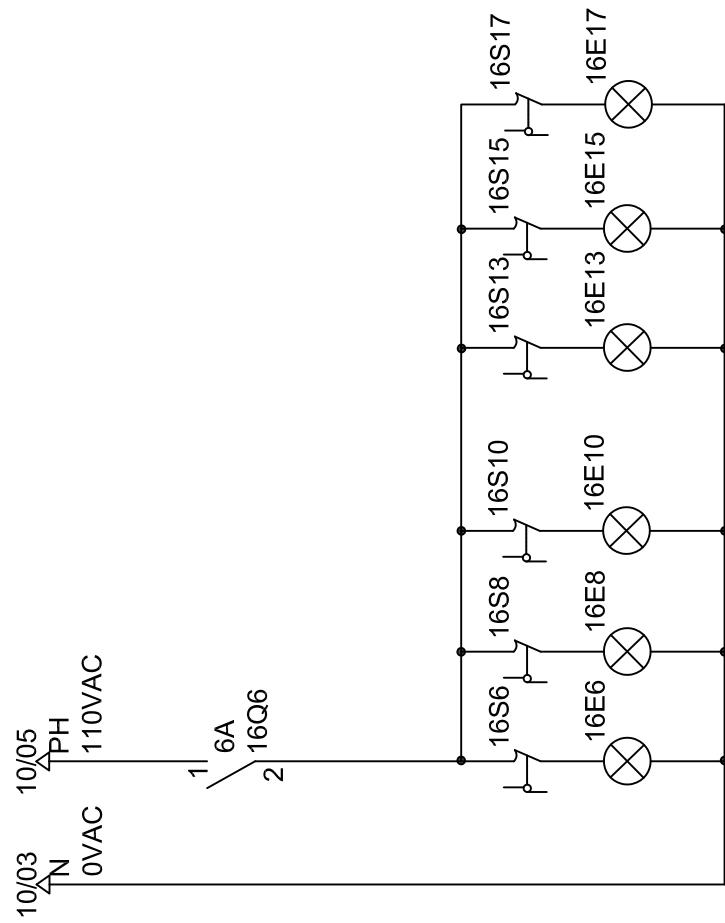


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03-03-2014

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VINCENT HUANG

CHECKED BY:

JEFF LEE

DRAWN BY:

INTEP/LAST GROUP, Ltd.

AMTOPP DIV., MIE DEPT.

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LIGHTING BOARD

INTEPLAST GROUP, Ltd.
AMTOPP DIV., MIE DEPT.

JEFF LEE

VINCENT HUANG

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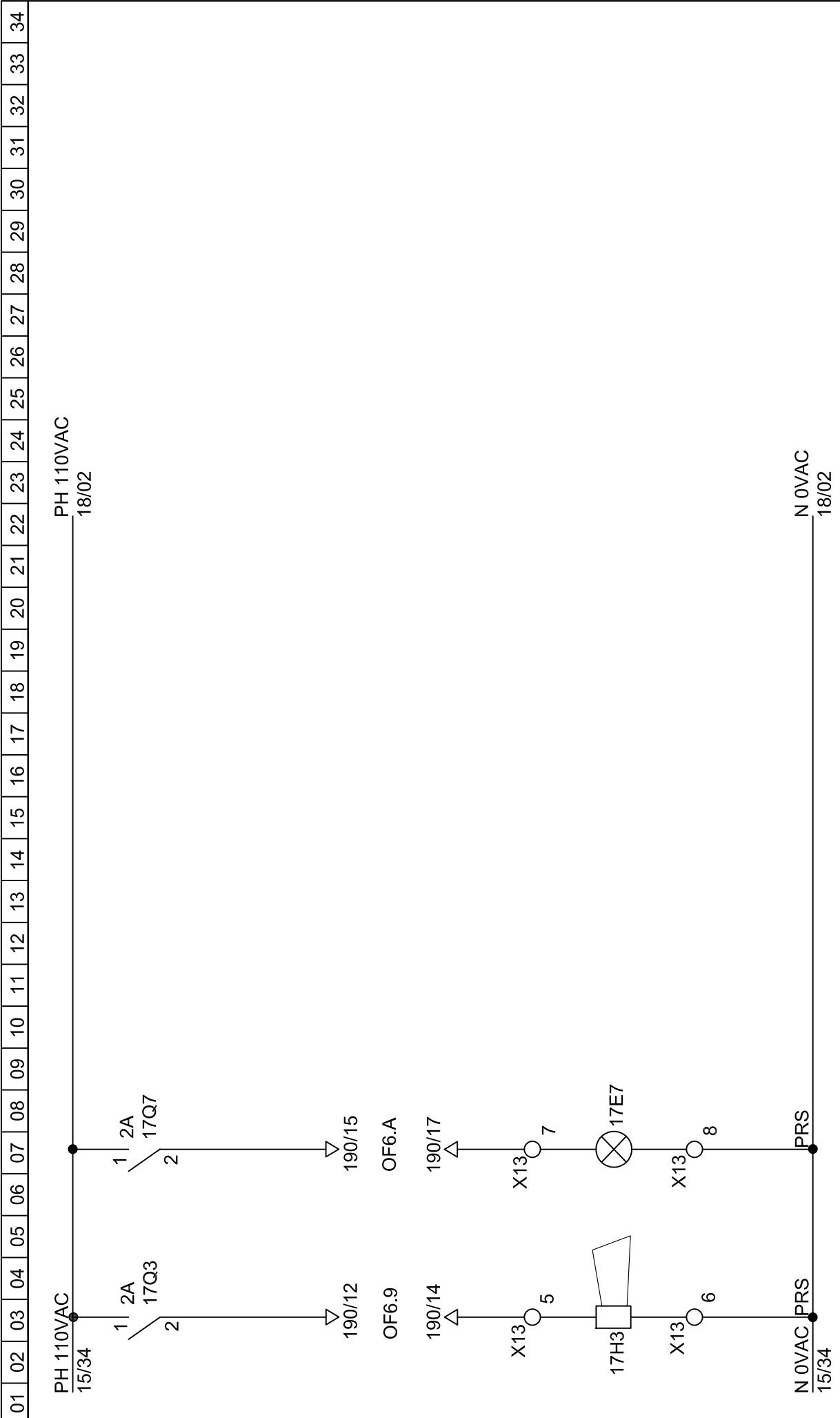
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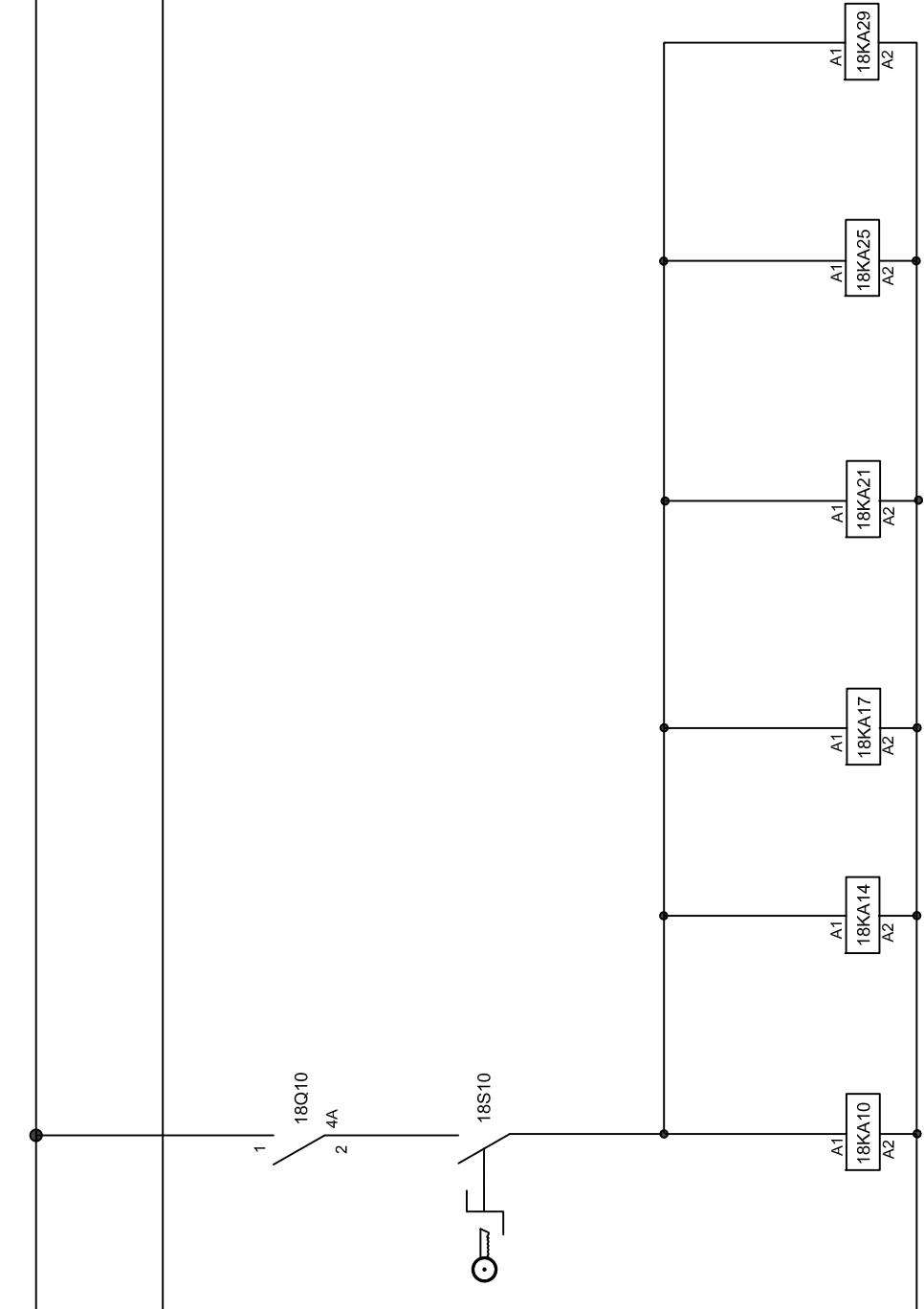
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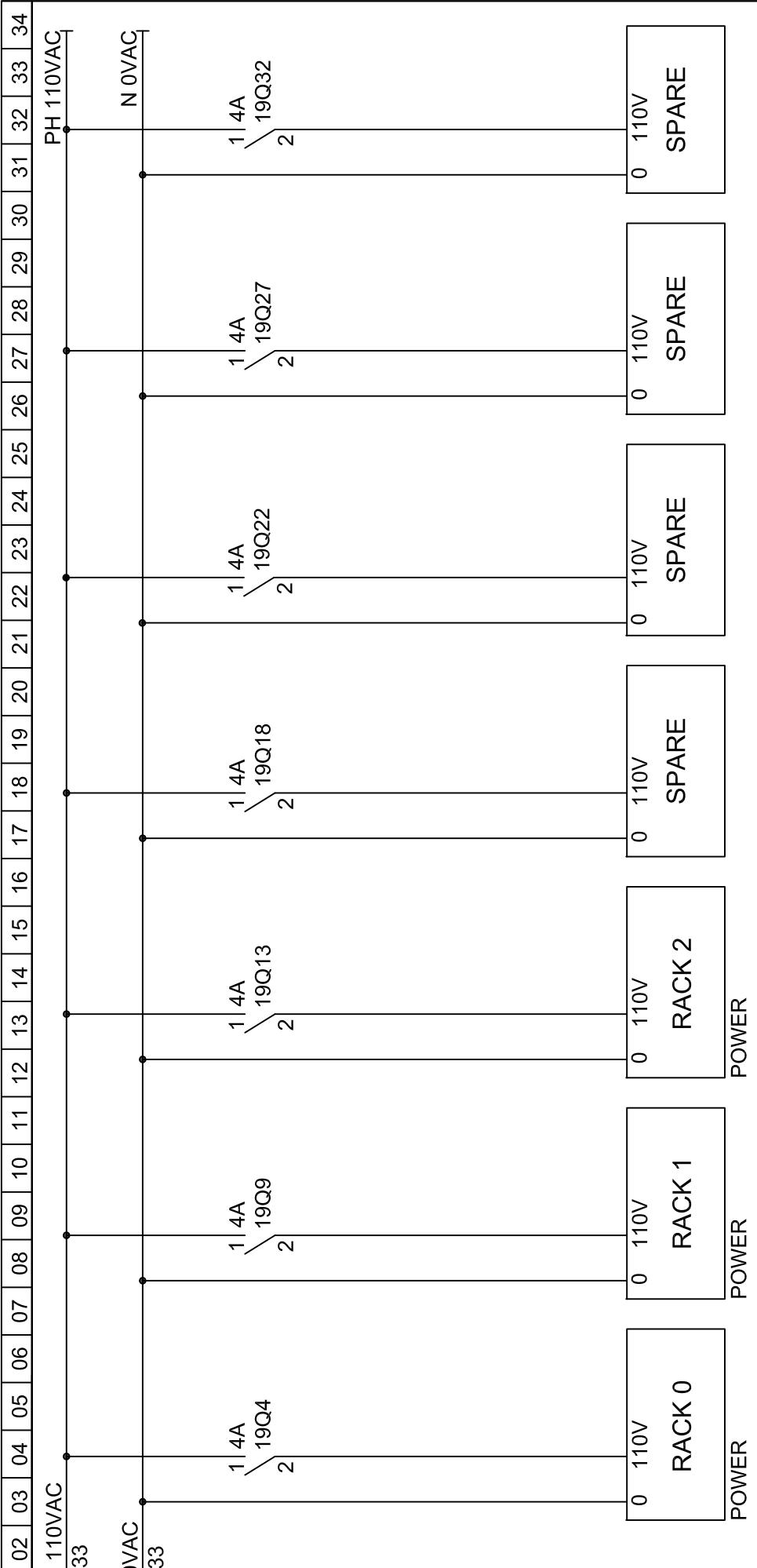
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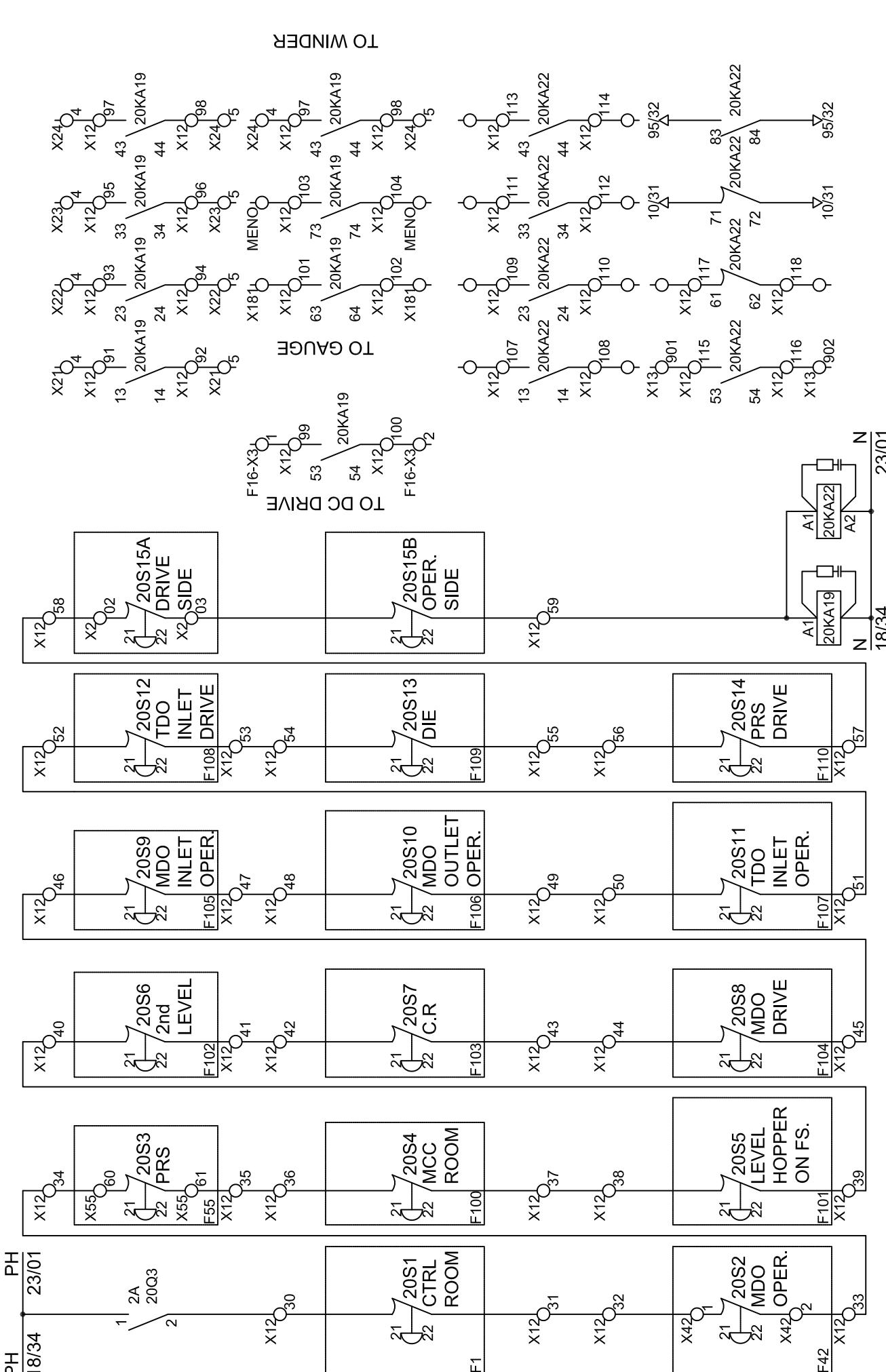
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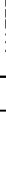


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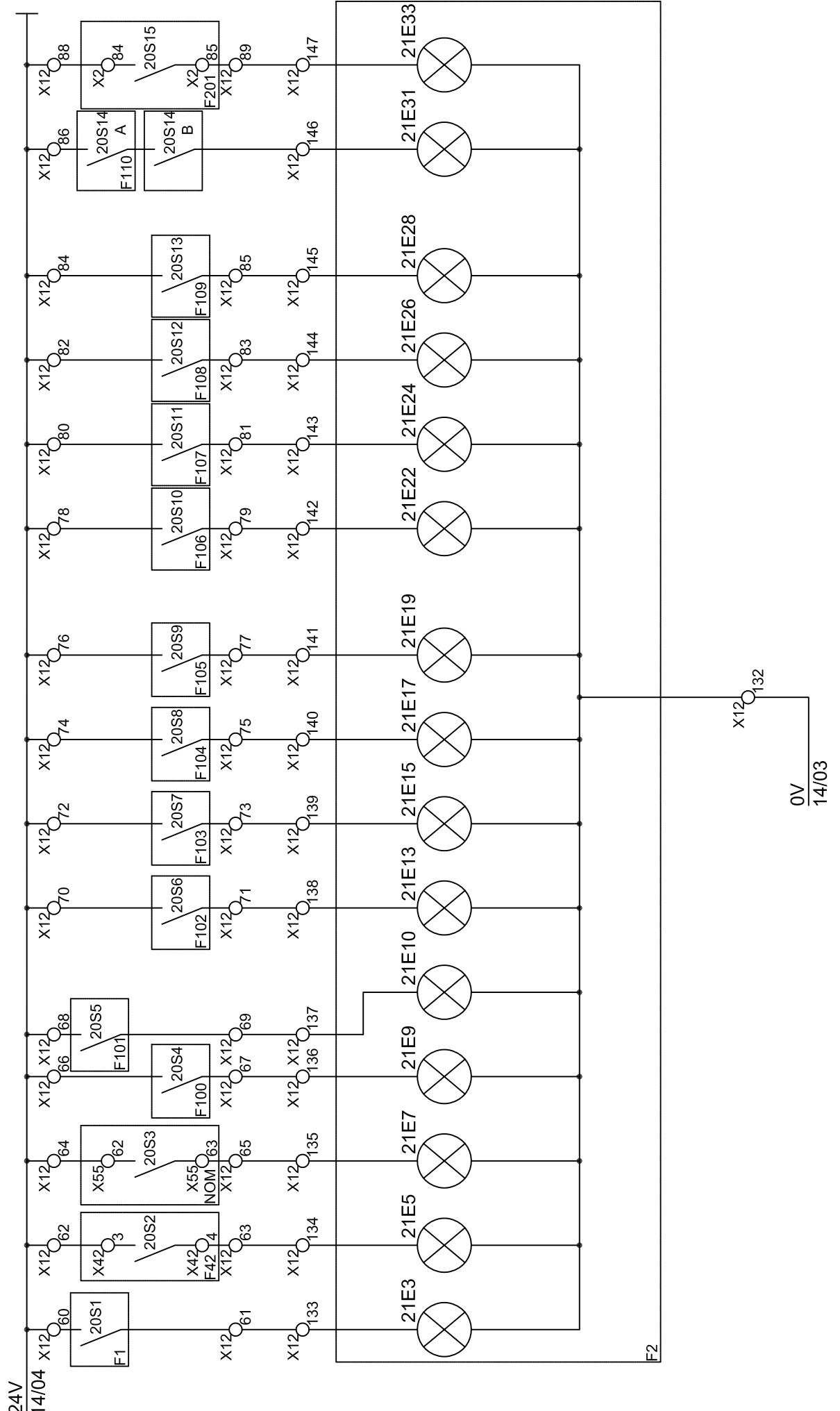






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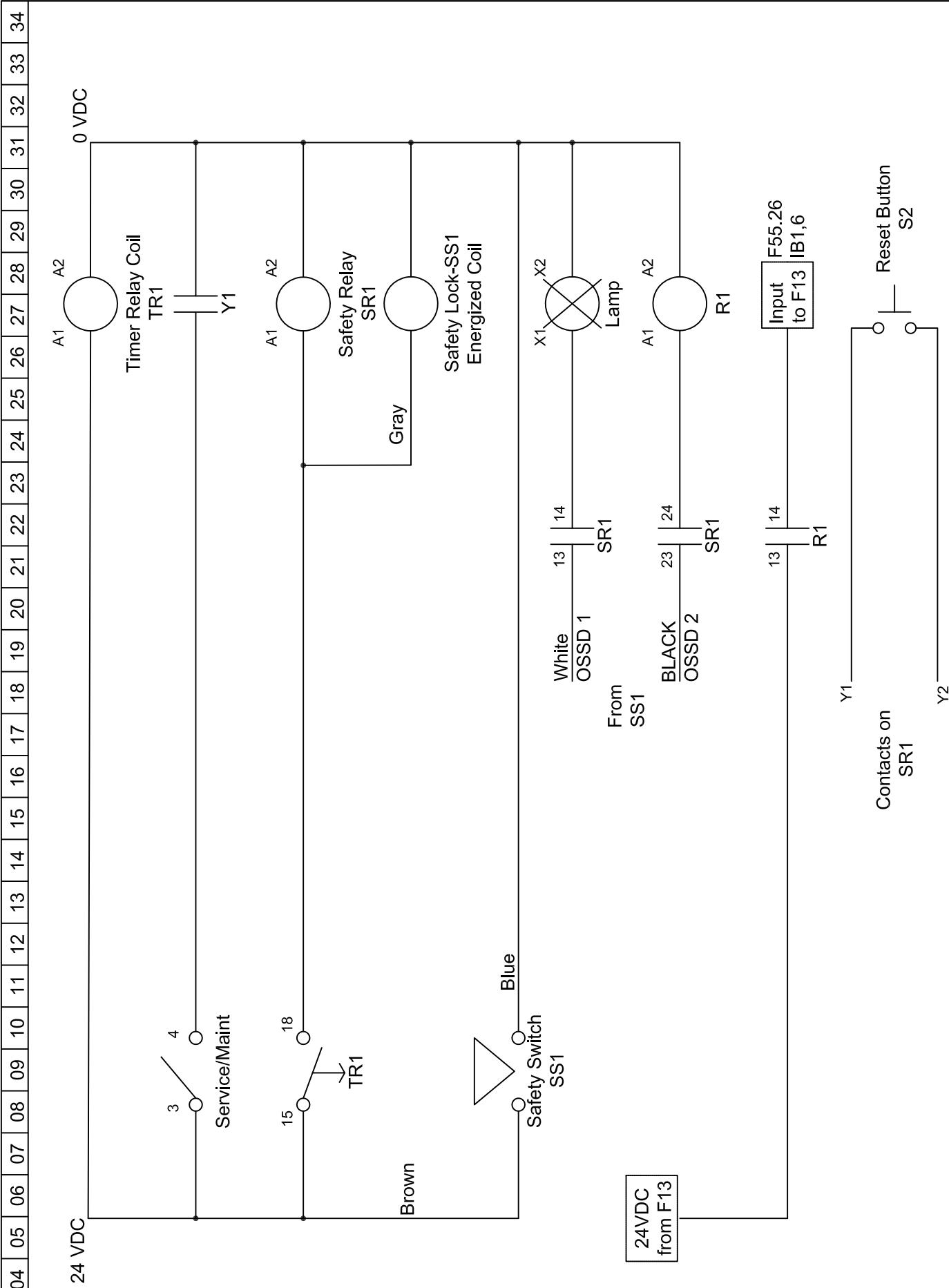
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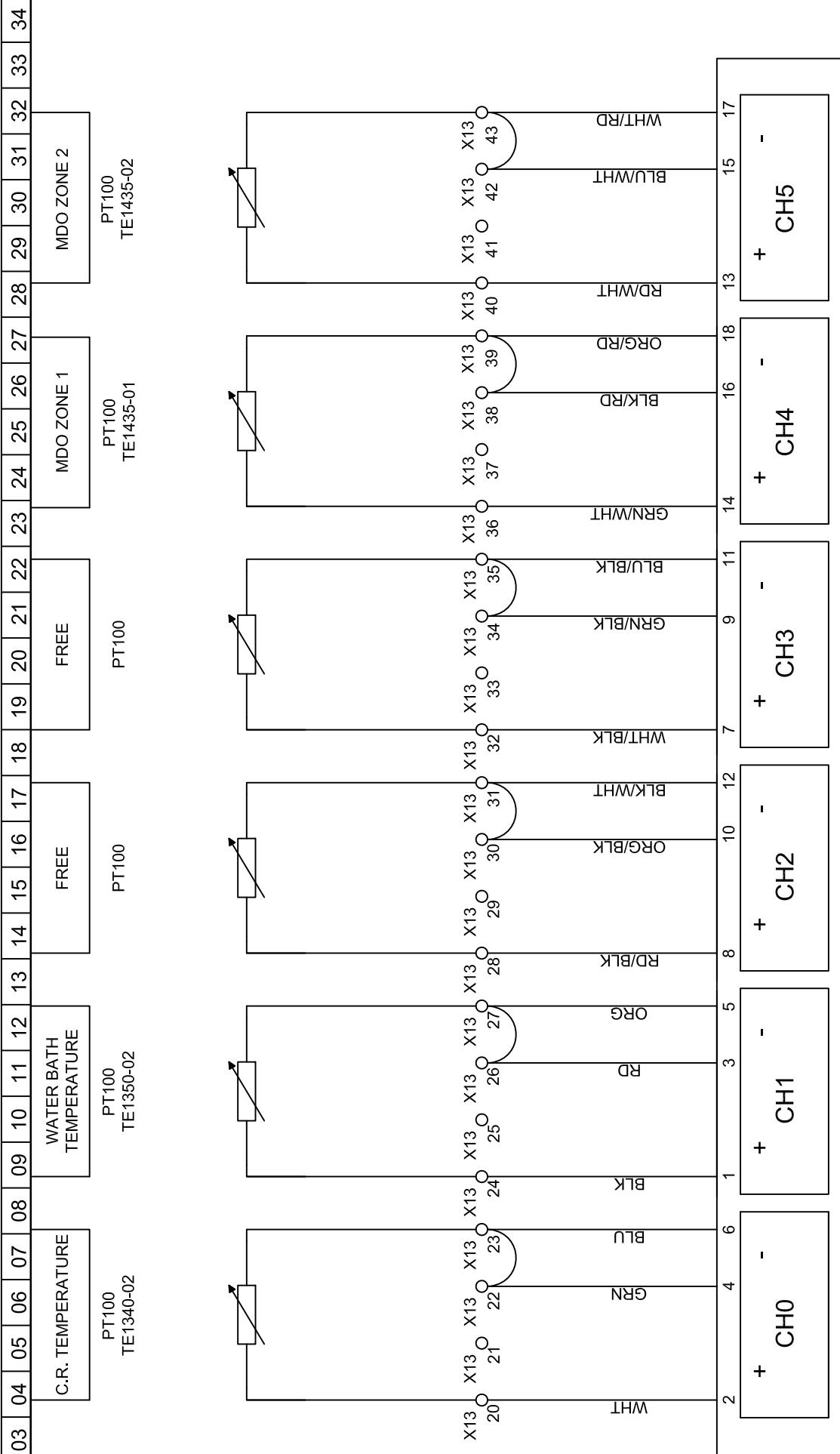
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			DRAWN BY	Bryan Hong	
			CHECKED BY	Jim Harrison	

SAFETY GATE



RACK 0 / SLOT 1
Allen Bradley 1756-IR12

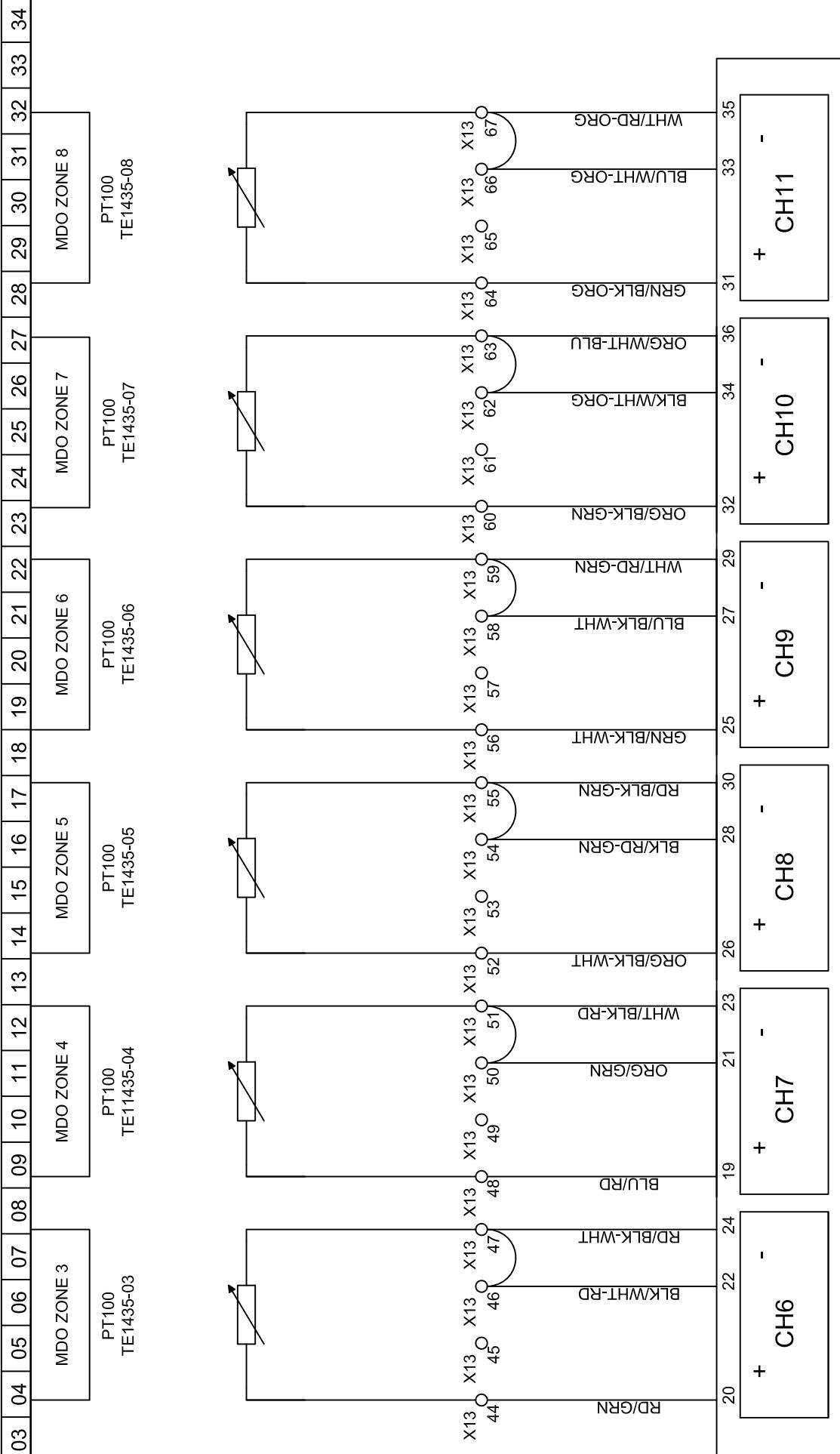
Allen Bradley 1756-IR12

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INTEPLAST GROUP Ltd. AMTOPP DIV. M/E DEPT.																																		
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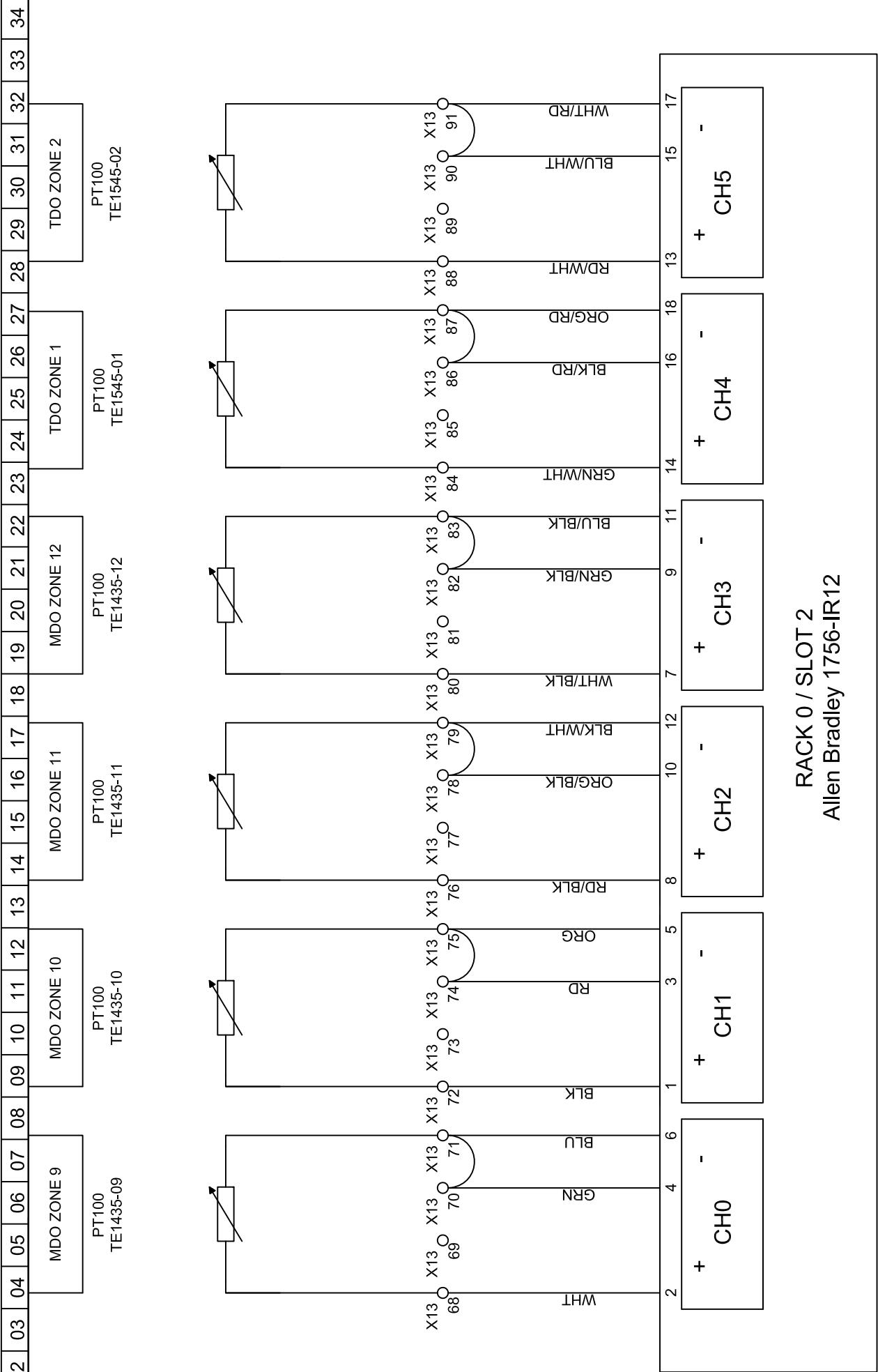
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Allen Bradley 1756-IR12

P.L.C. ANALOG INPUT
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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.
DRAWN BY	Bryan Hong
CHECKED BY	Jerry Wu





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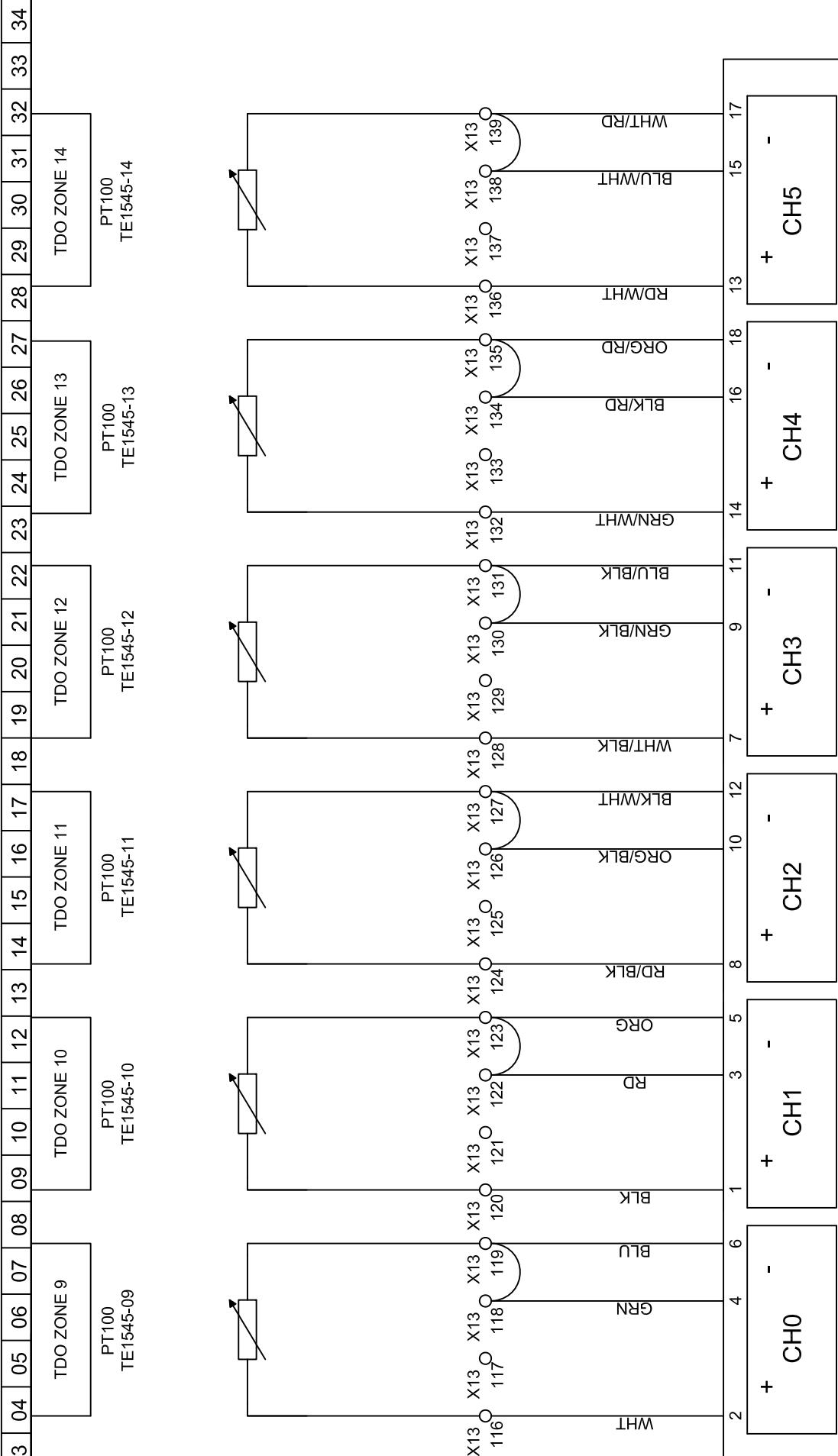
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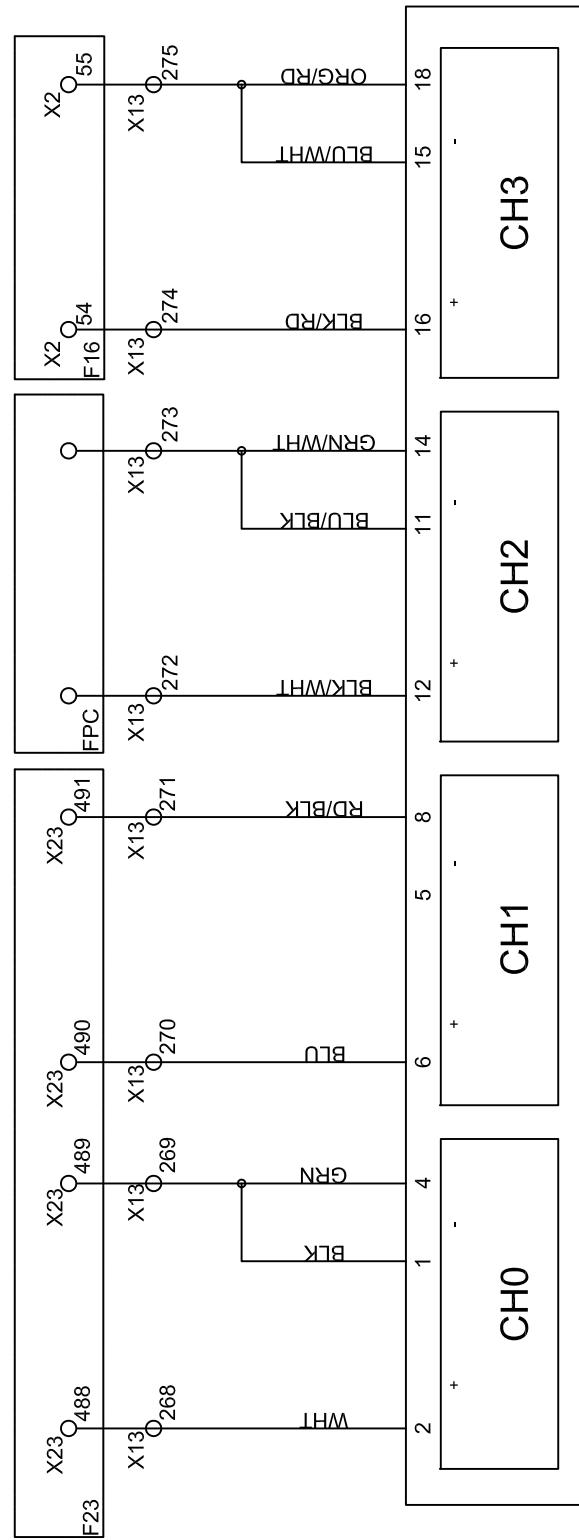
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F23																																	



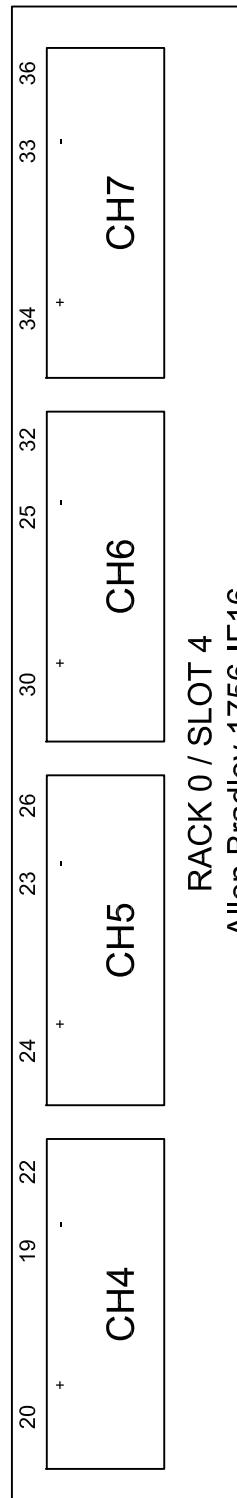
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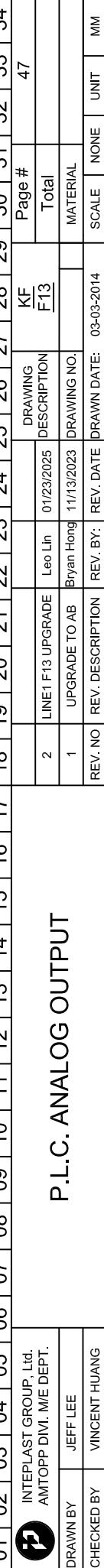
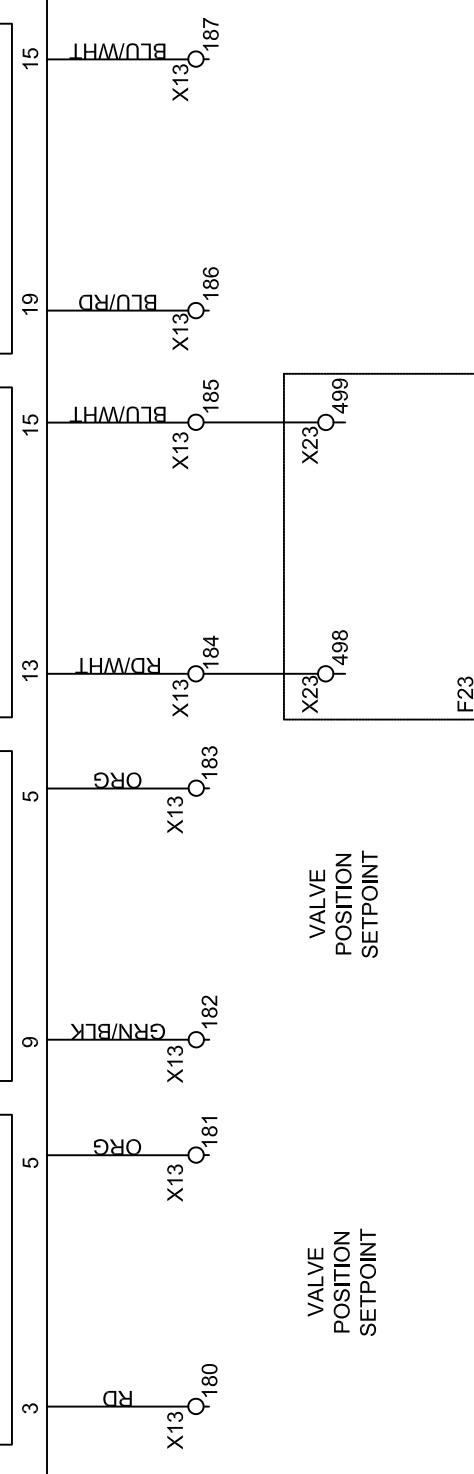
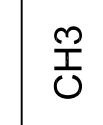
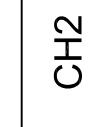
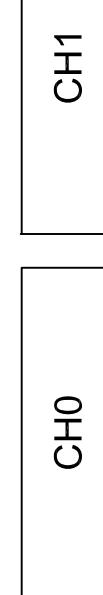
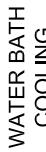
8 P.L.C. ANALOG INPUT

Page # 43

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Allen Bradley 1756-IF16





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TV1435-02

TV1435-04

TV1435-03

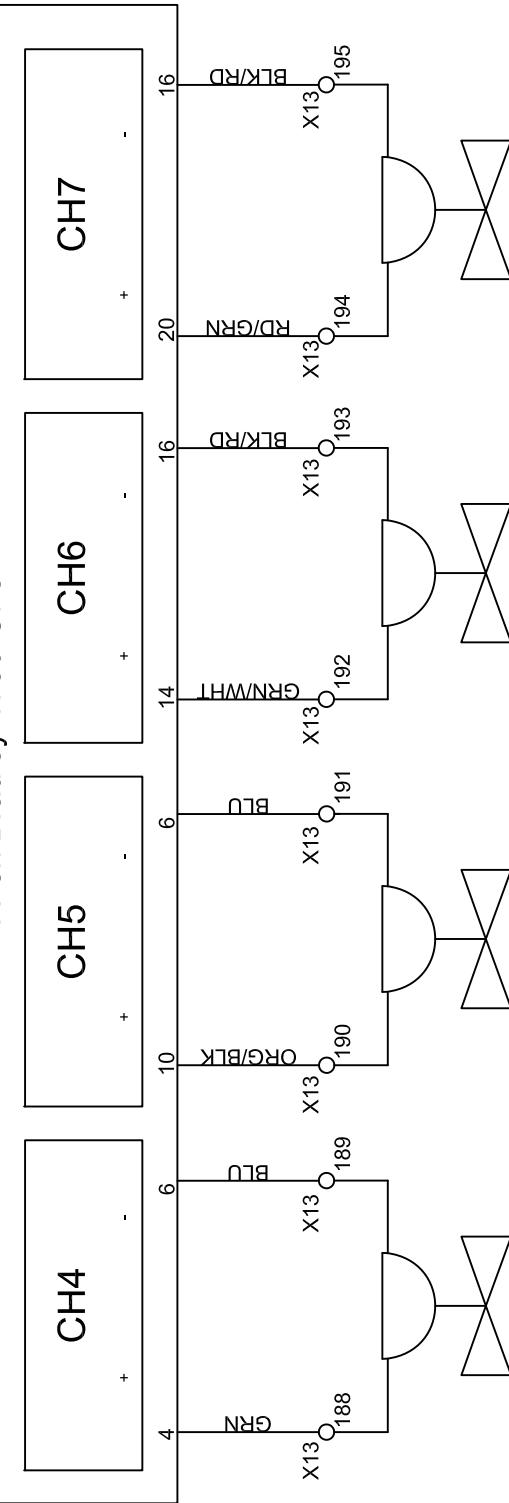
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OW45_4

OW45_6

OW45_5

RACK 0 / SLOT 5
Allen Bradley 1756-OF8



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CHECKED BY	VINCENT HUANG																									SCALE							
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	INTEPLAST GROUP, Ltd.	AMTOPP DIV. MIE DEPT.																													
DRAWN BY	JEFF LEE																														
CHECKED BY	VINCENT HUANG																														

P.L.C. ANALOG OUTPUT

Page #

48

Total

MATERIAL

SCALE

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UNIT

MM



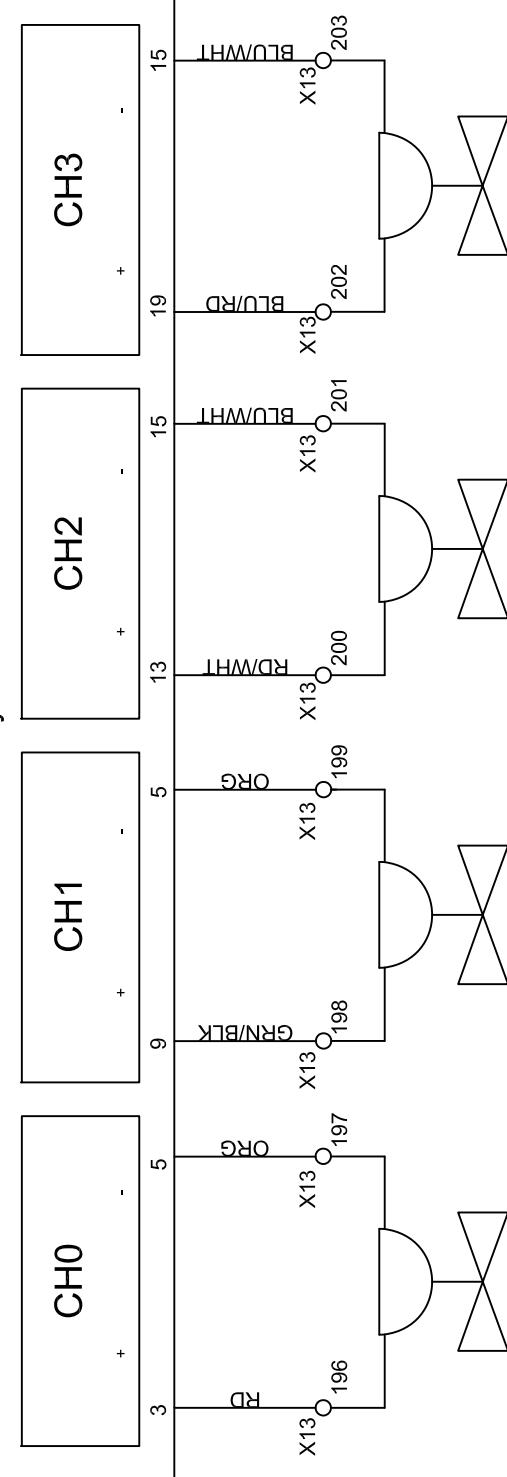
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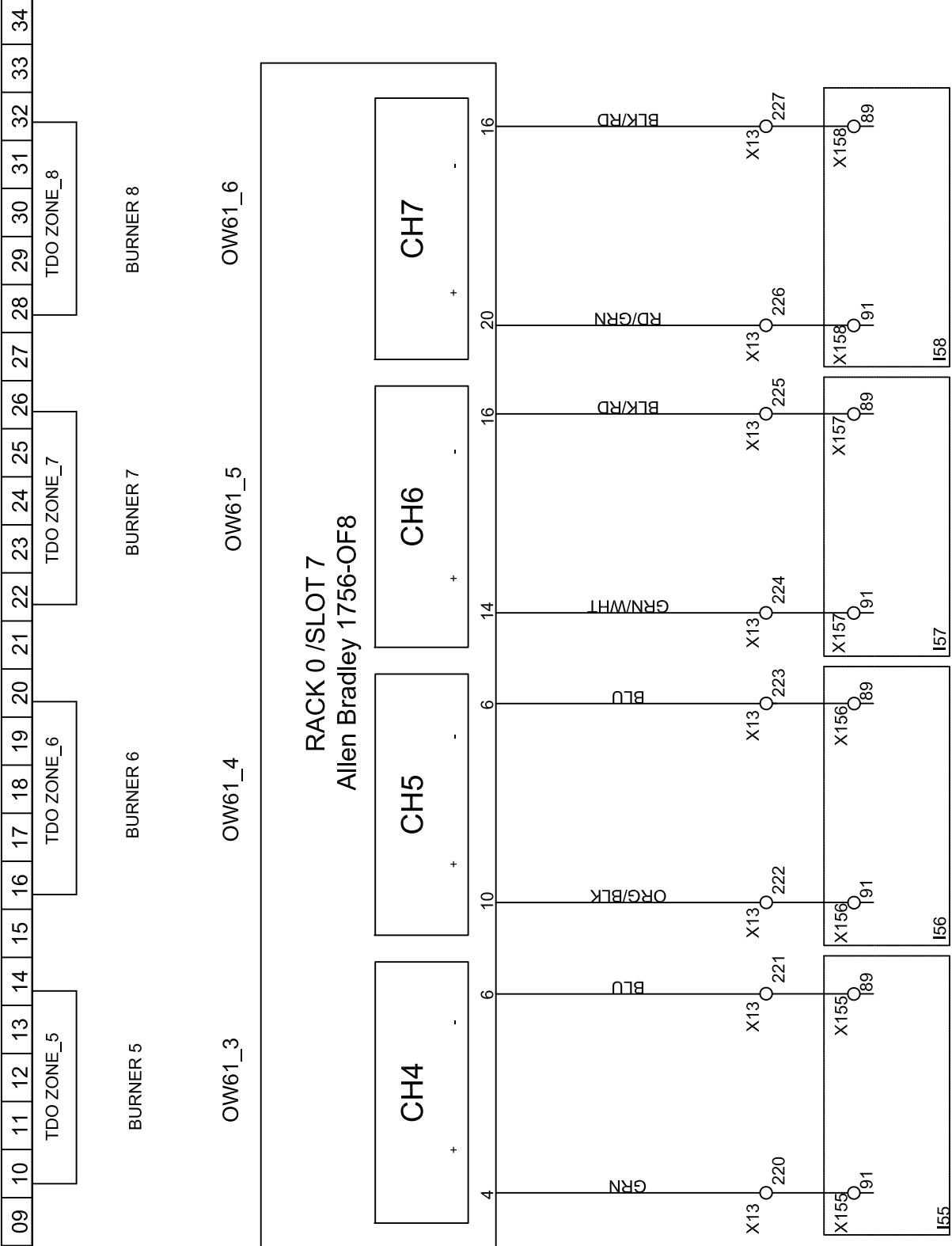
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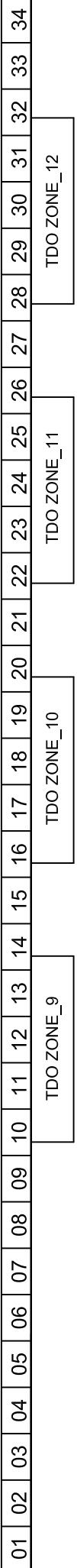
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Allen Bradley 1756-OF8



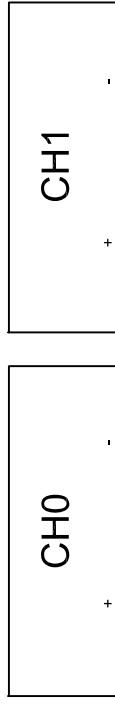
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MDO ZONE_5												MDO ZONE_6						MDO ZONE_7						MDO ZONE_8																				
INTEPLAST GROUP, Ltd. AMTOPP DIV. MIE DEPT.	4 P.L.C. ANALOG OUTPUT																													Page #	49													
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CHECKED BY	Vincent Huang																												MATERIAL															
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REV. DATE	DRAWN DATE:																												03-03-2014															



P.I.C. ANALOG OUTPUT																	Page #																
																		53															
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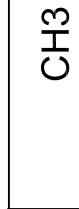
Allen Bradley 1756-OF8



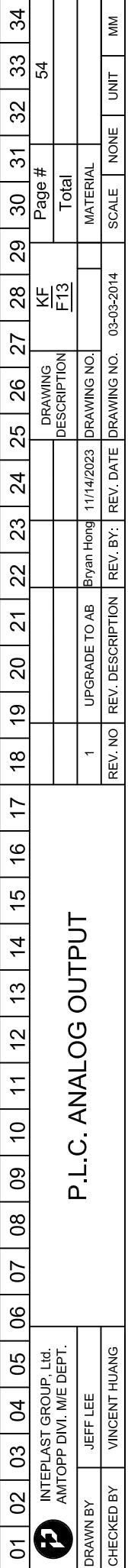
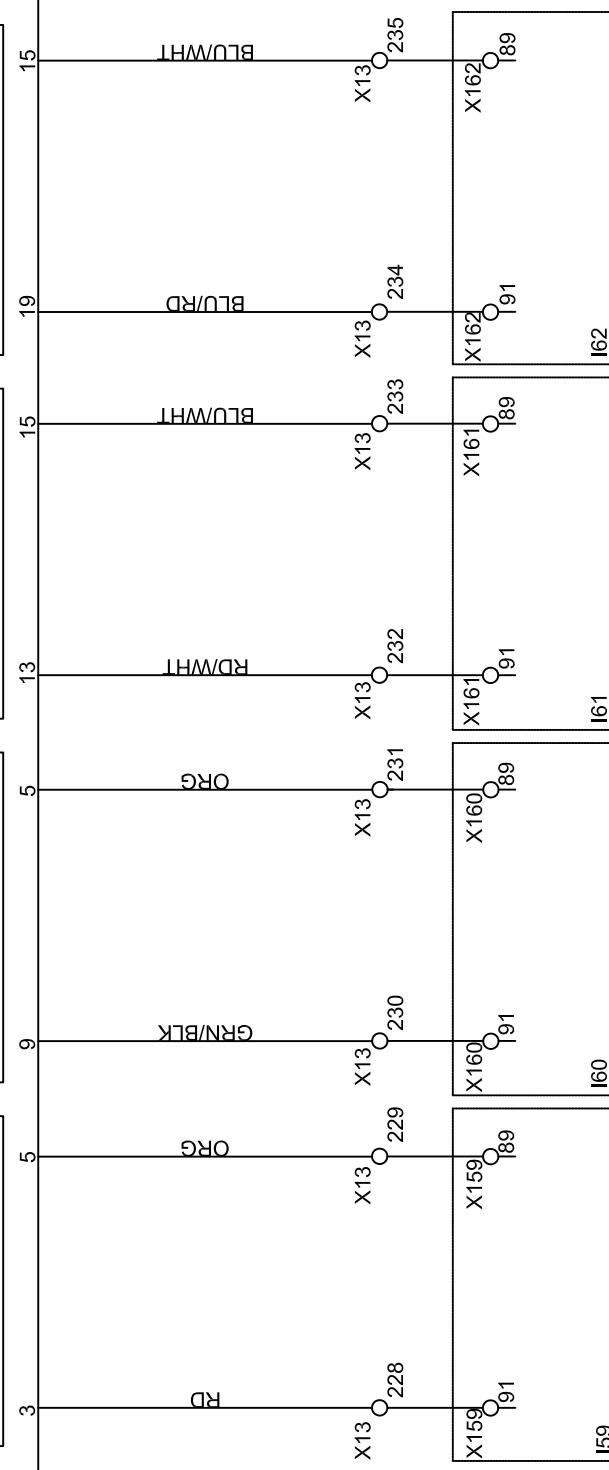
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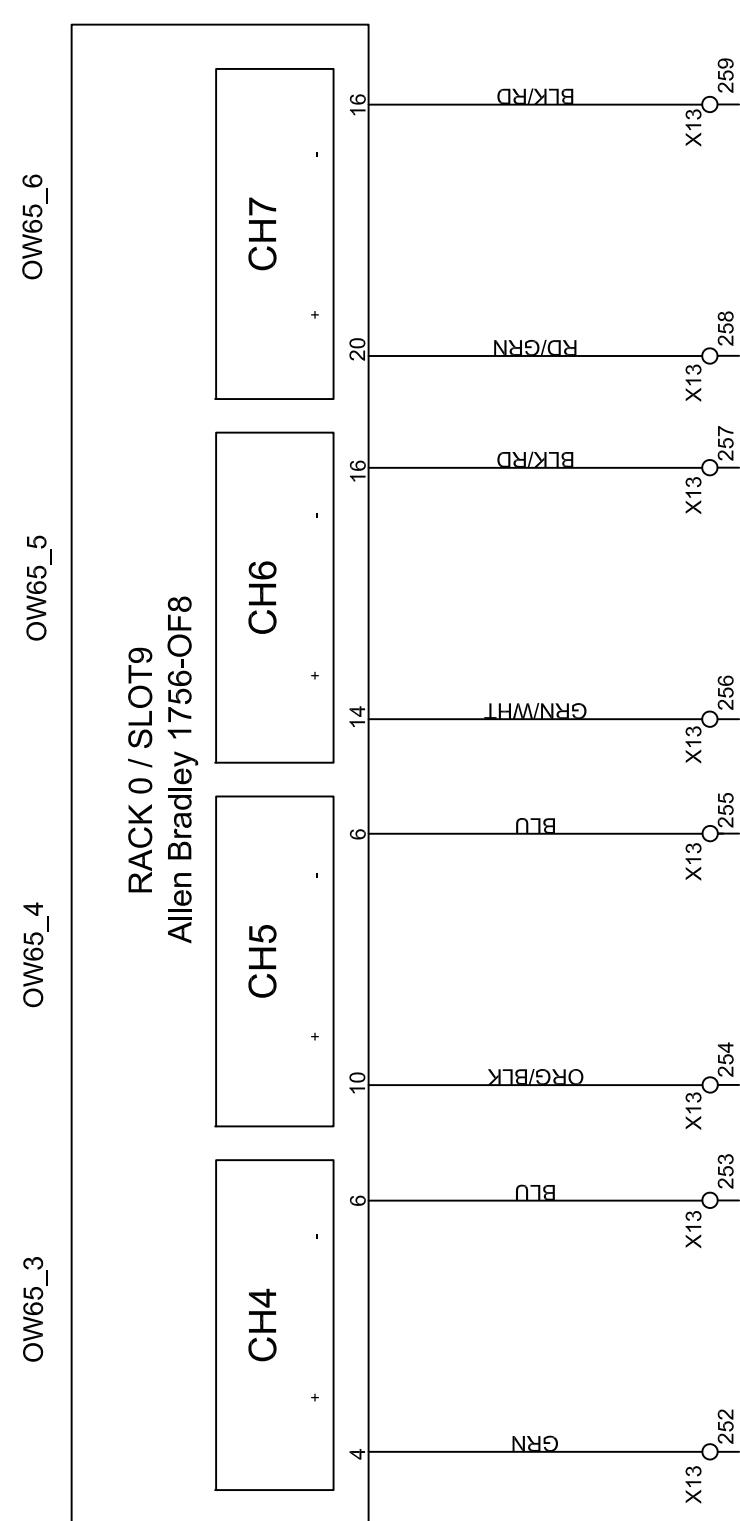


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Allen Bradley 1756-OF

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OW65 4

OW65 5

OW65 6

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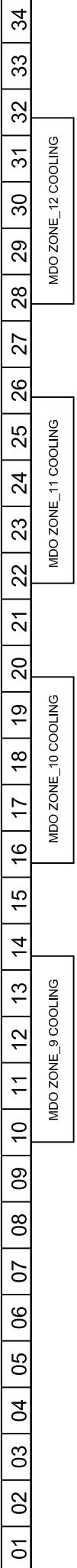
FREE

FREE

FREE

	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.
DRAWN BY	JEFF LEE
CHECKED BY	VINCENT HUANG

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TV1435-16

TV1435-15

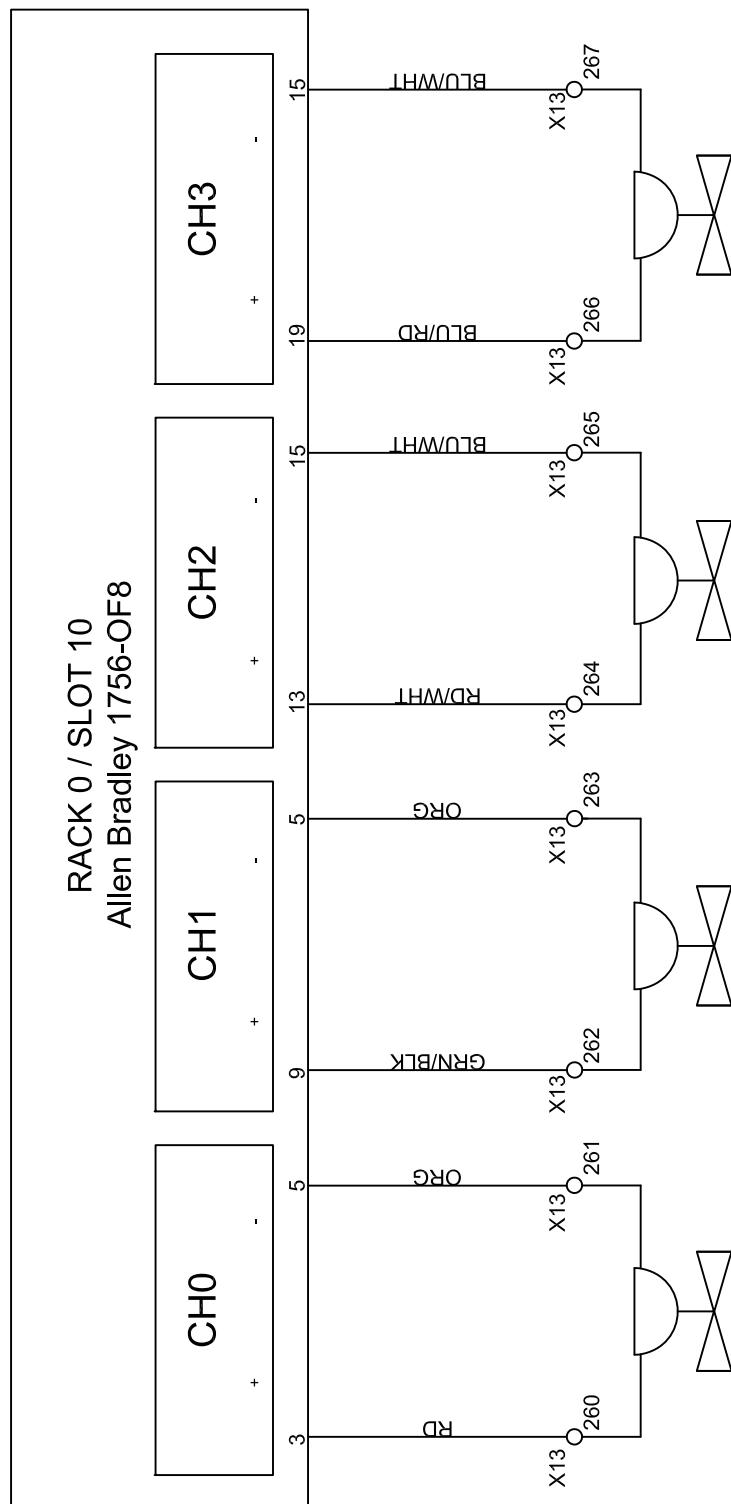
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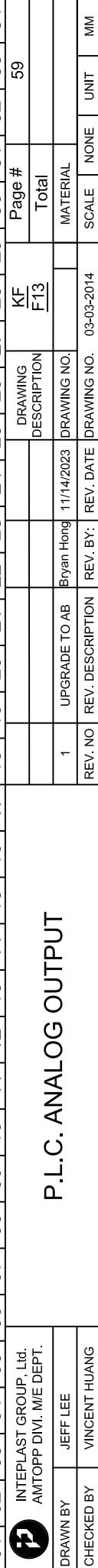
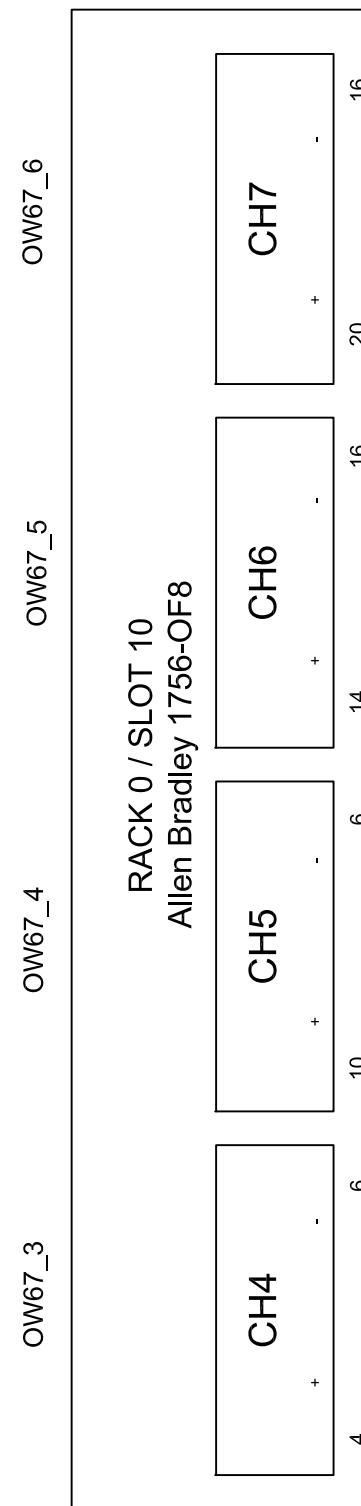
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QW66 4

RACK 0 / SLOT 10
Allen Bradley 1756-OF



B1 C ANN OC OITBI IT



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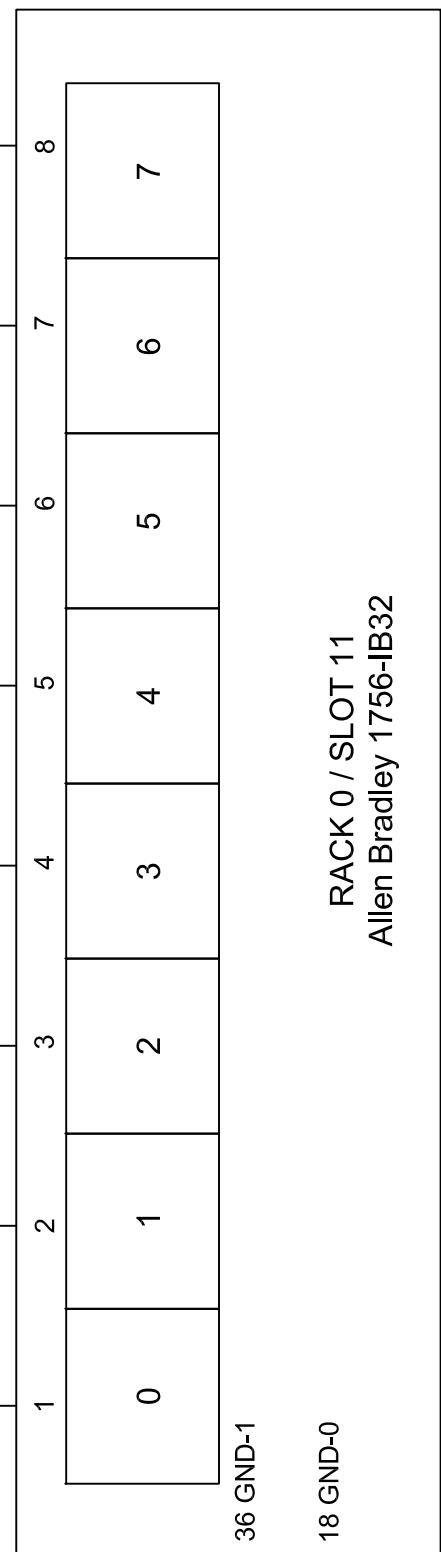
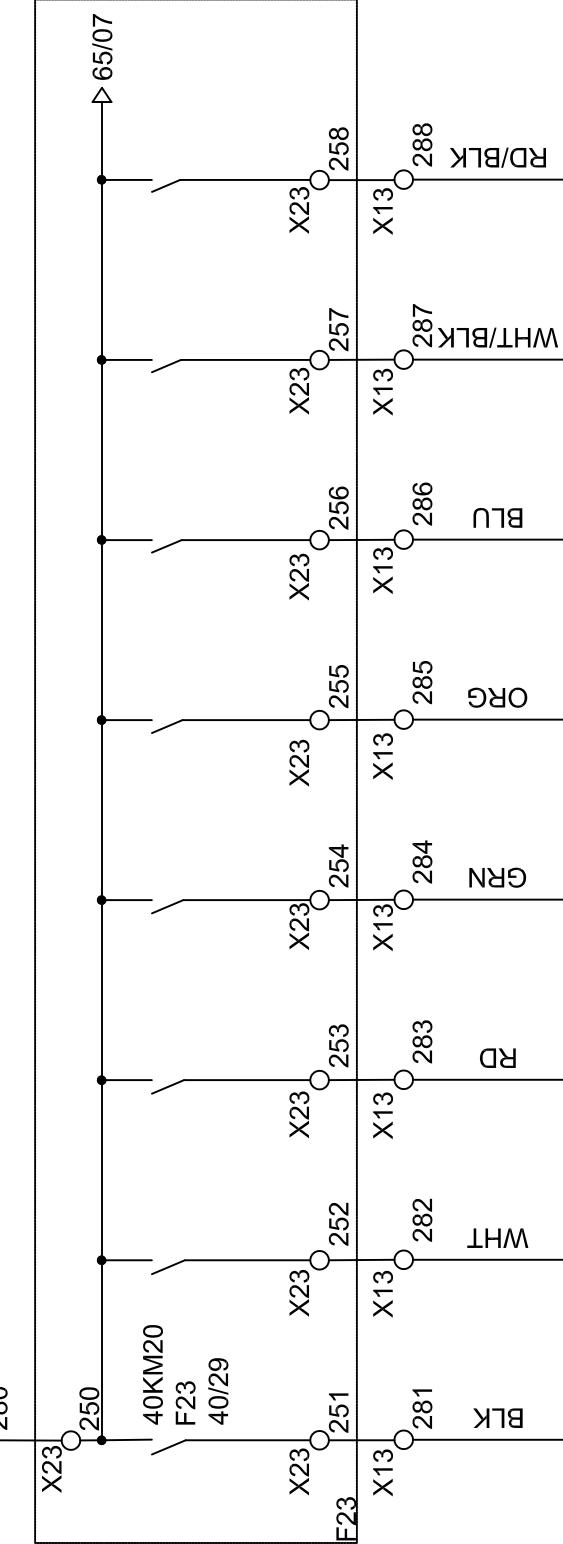
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FAN FOR EXHAUST HOOD	AIR KNIFE BLOWER	FILM DRYING BLOWER	C.R. DRYING BLOWER	C.R. BRAKE	FREE	AUX. WINDER NUM.1																											
M1263-01	M1310-01	M1310-02	M1310-03	M1330-01	Y1302-01	M1360-01 & 02																											

24 VDC / 12Q4
12/04



0 VDC
12/04

ORG/WHT-BLU

18 GND-0

ORG/RD

RACK 0 / SLOT 11
Allen Bradley 1756-IB32

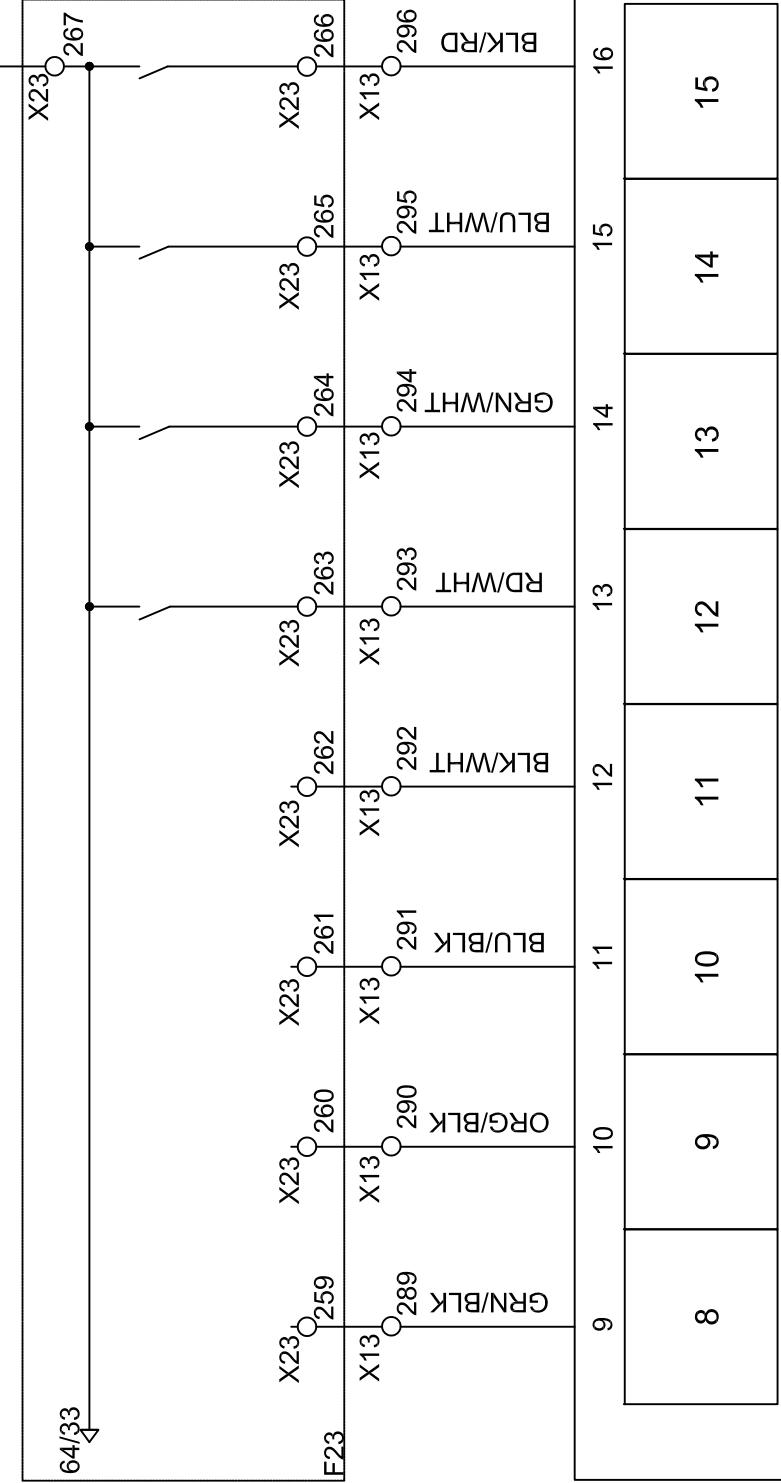
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INTEPLAST GROUP, Ltd.	AMTOPP DIV., MIE DEPT.																																
DRAWN BY	JEFF LEE																																

CHECKED BY	VINCENT HUANG	REV. NO	REV. DESCRIPTION	DRAWN DATE	REV. DATE	DRAWN DATE	REV. NO	REV. DESCRIPTION	DRAWN NO.	DRAWN DATE	KF	Page #	64

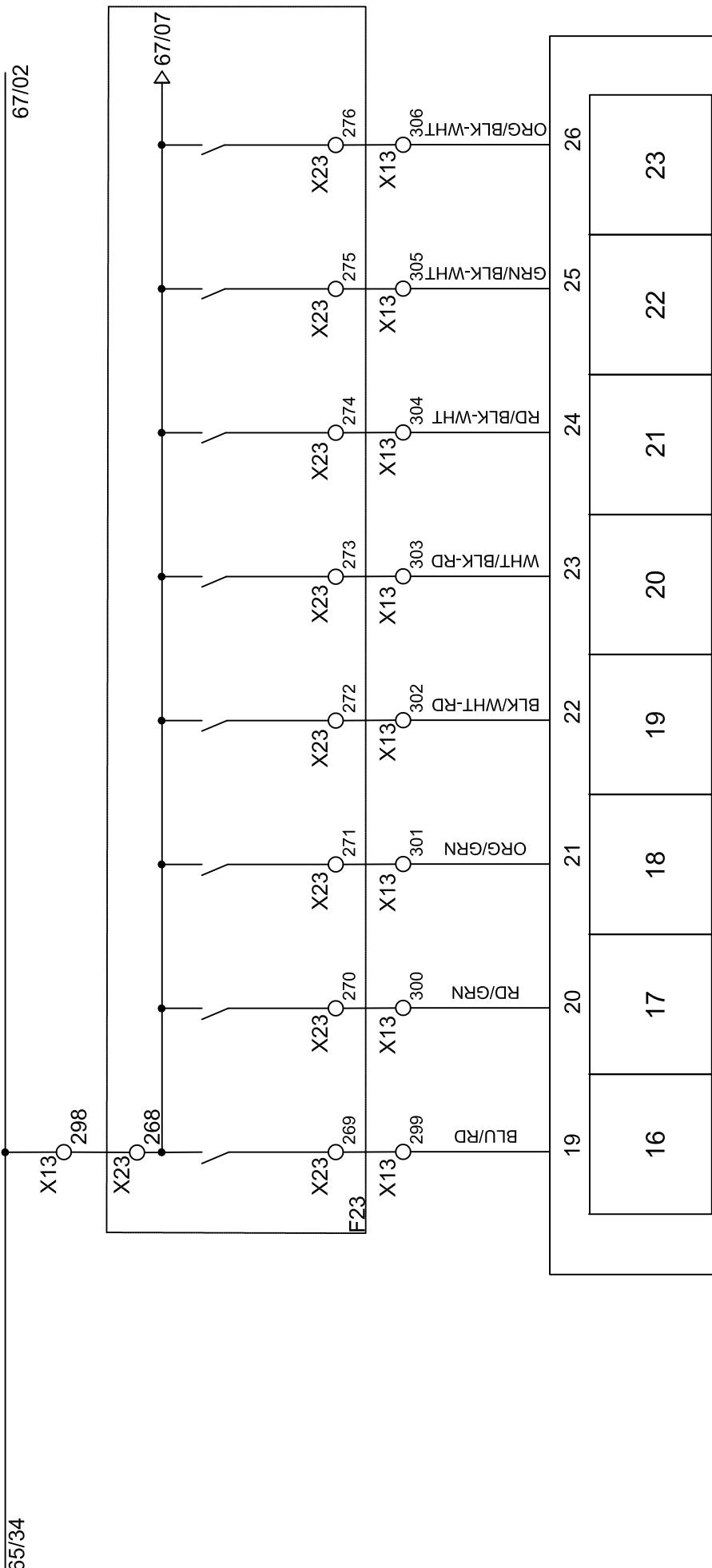
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34/34



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Allen Bradley 1756-IB3

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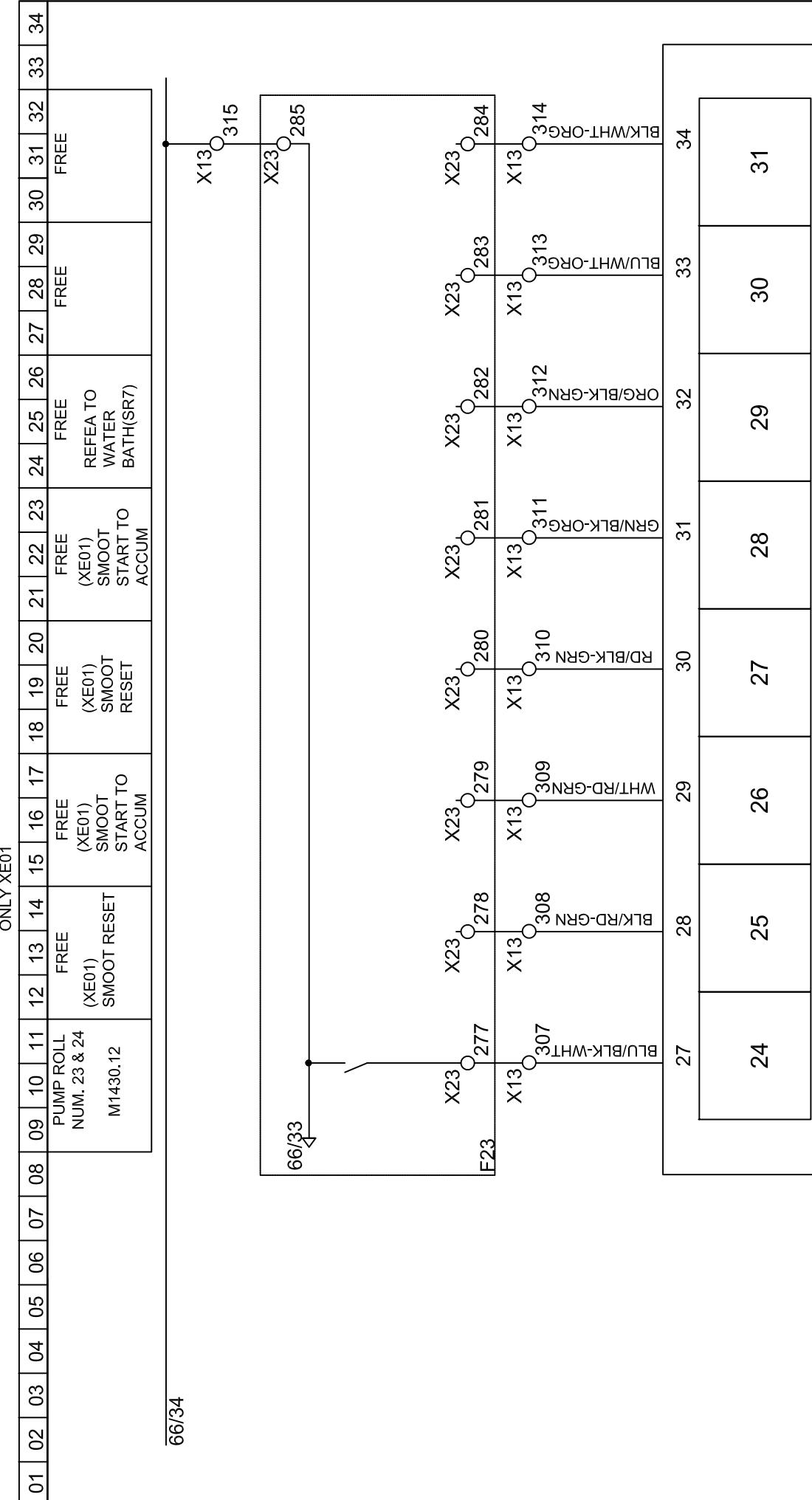


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Allen Bradley 1756-IB3

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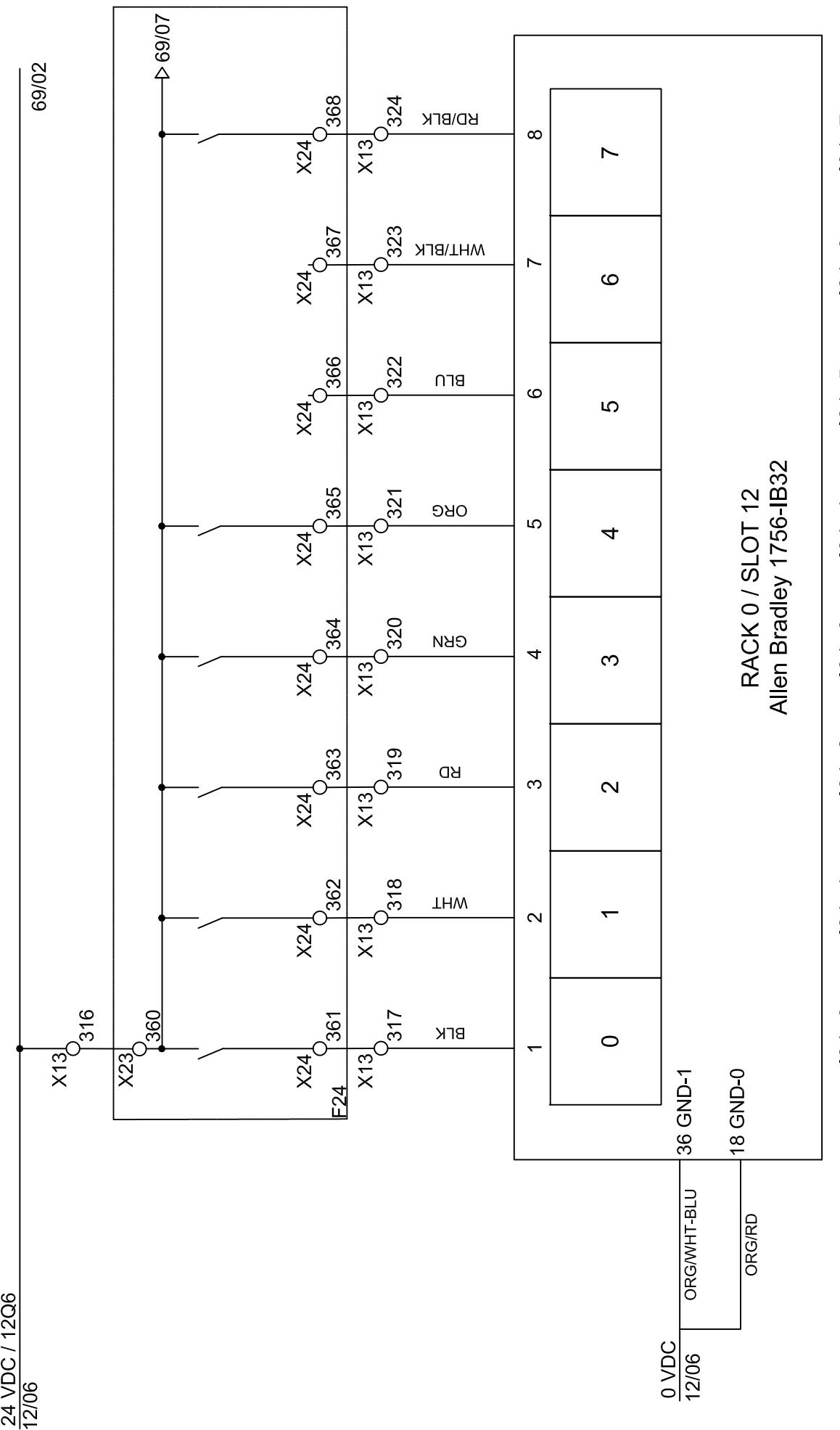
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BRYAN HONG															DRAFTER															NONE			
11/16/2023															DRAWN NO.															UNIT			
UPGRADE TO AB															REV. DATE															MM			



RACK 0 / SLOT 11
Allen Bradley 1756-IB32

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Allen Bradley 1756-IB3

18 GND-0

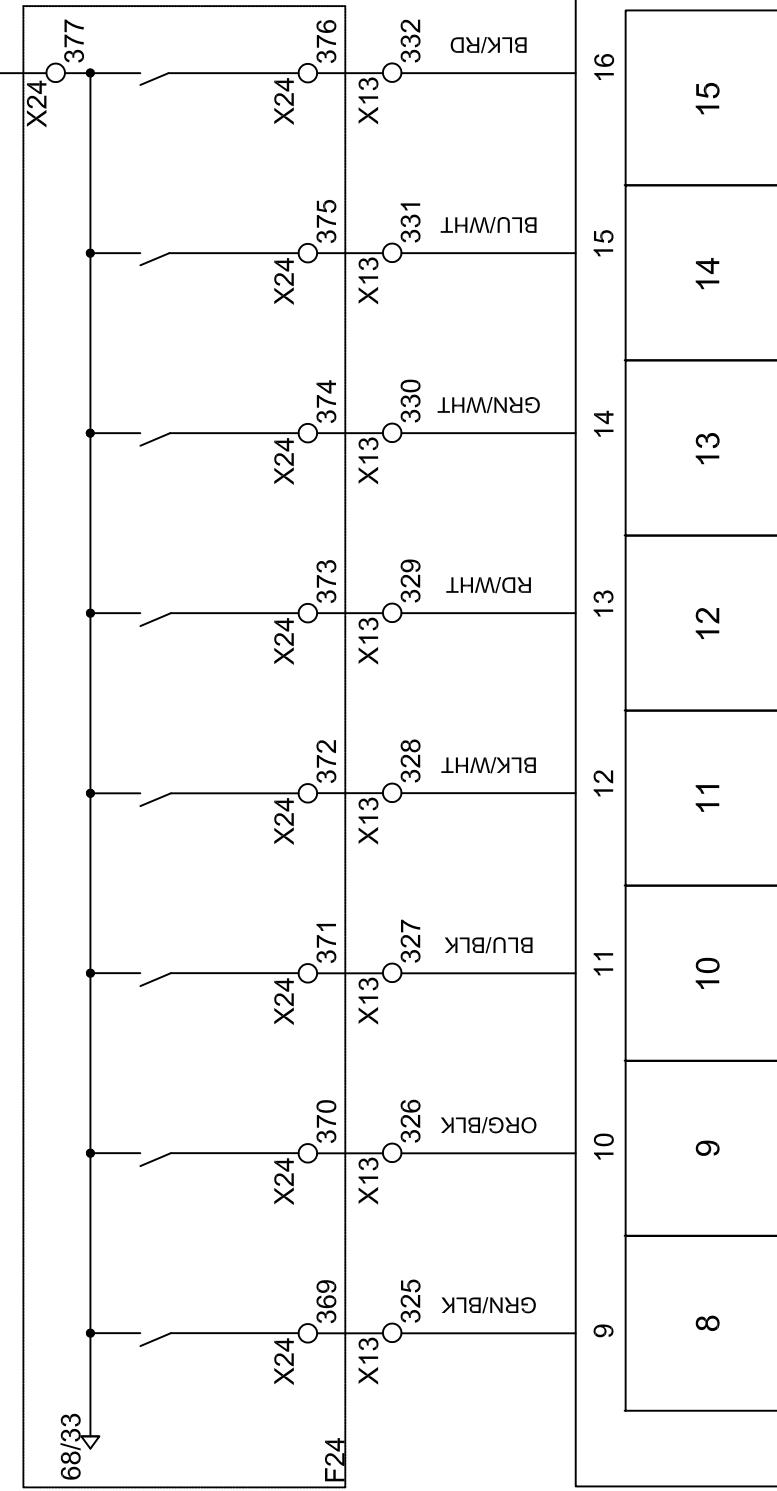
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32 P.L.C. DIGITAL INPUT

38/34

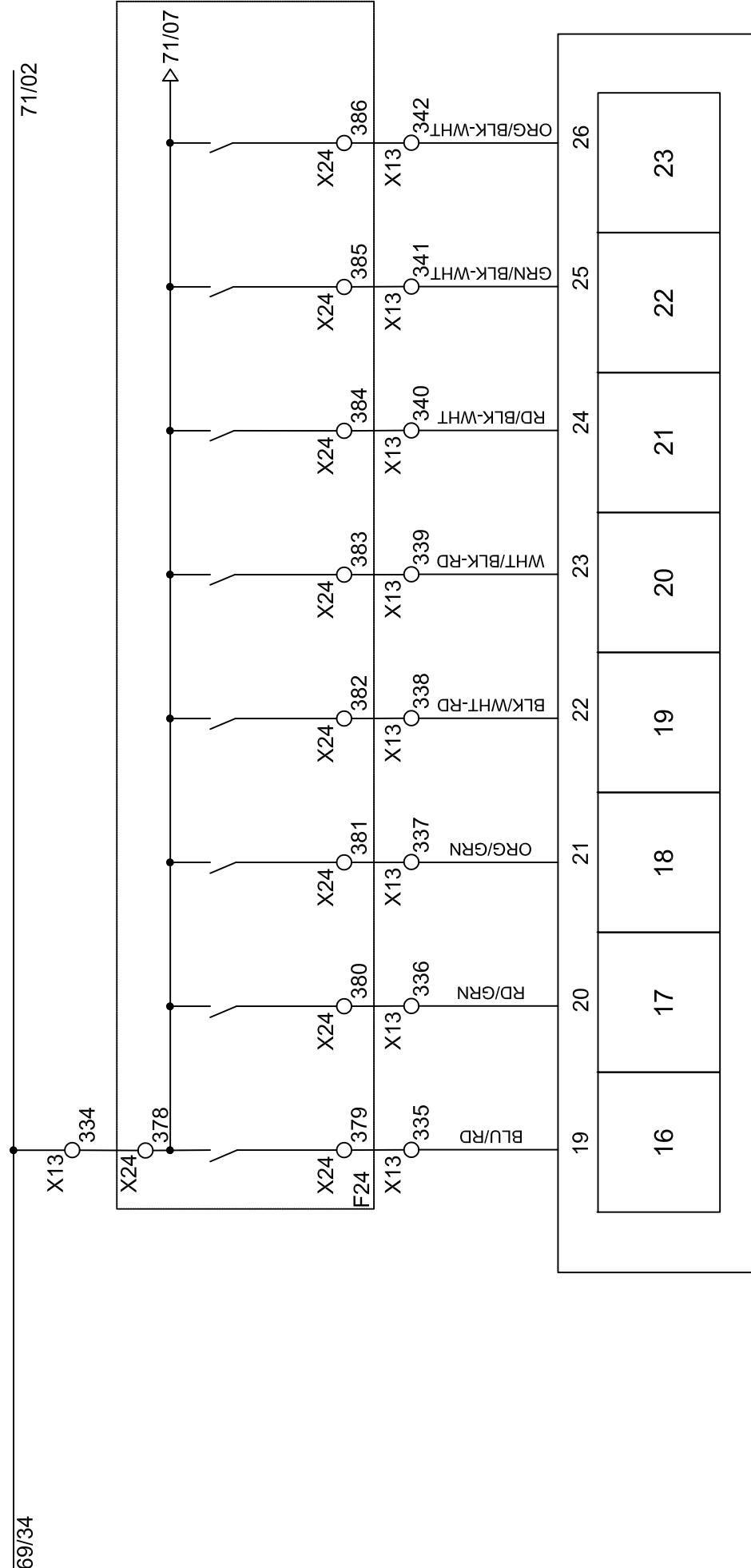
70/02



RACK 0 / SLOT 12
Allen Bradley 1756-IB32

|81 8 |81 9 |81 A |81 B |81 C |81 D |81 E |81 F

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AIR FAN ZONE 5	AIR FAN ZONE 6	AIR FAN ZONE 7	AIR FAN ZONE 8	AIR FAN ZONE 9																													
(L.S.)	(L.S.)	(L.S.)	(L.S.)	(L.S.)	M1520-05	M1520-06	M1520-07	M1520-08	M1520-09																								

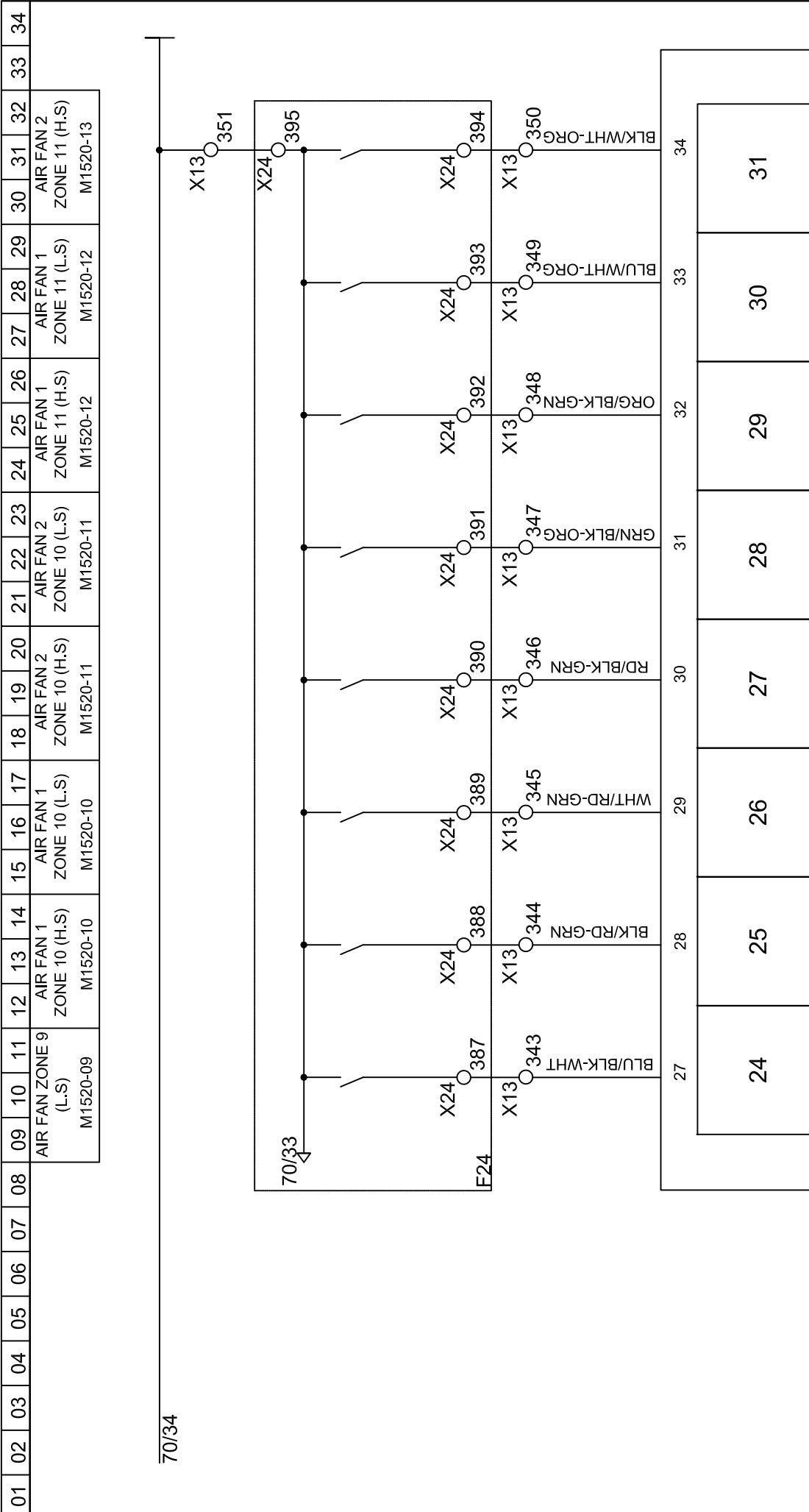


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Allen Bradley 1756-IB32

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32 P.L.C. DIGITAL INPUT



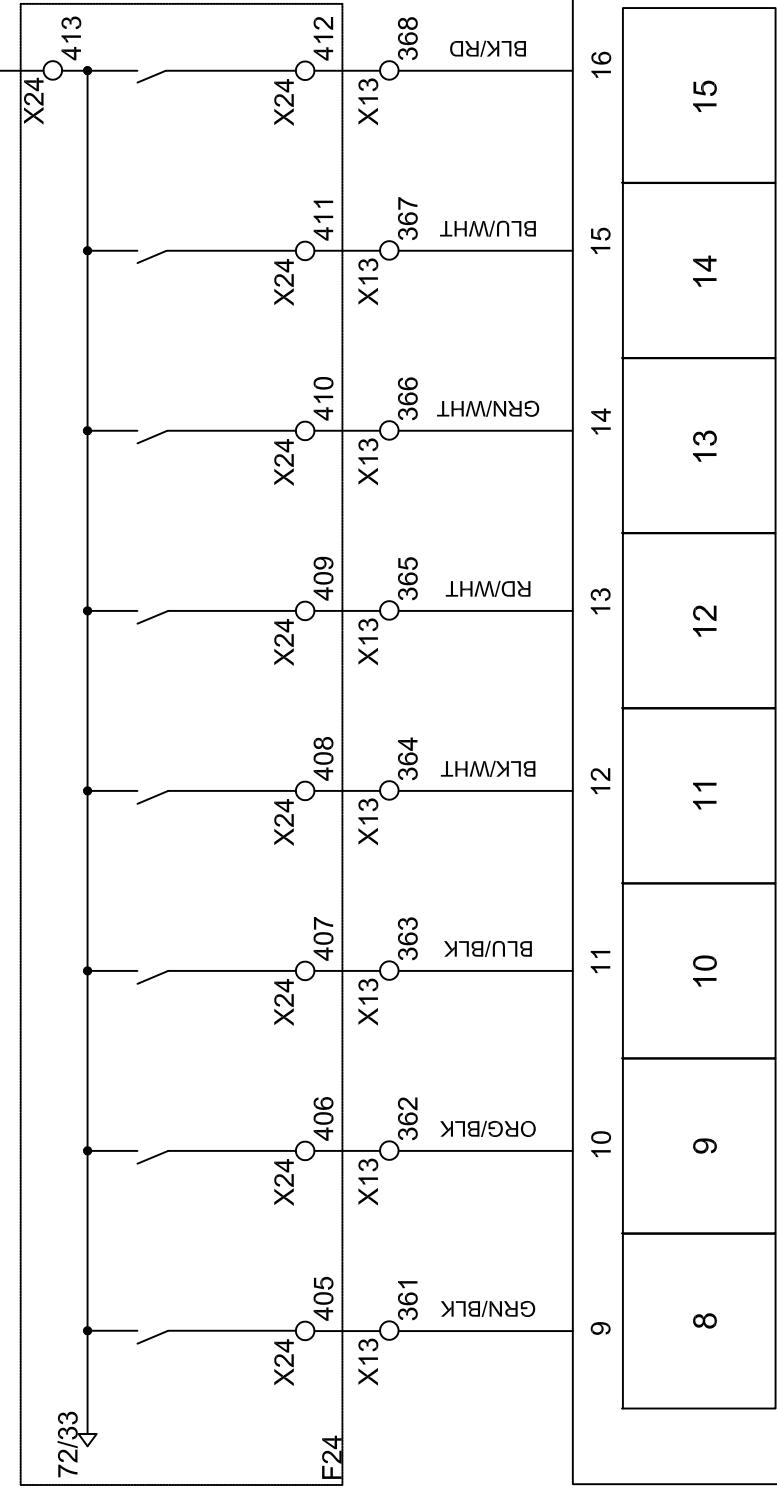
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Allen Bradley 1756-IB

|91 8 |91 9 |91 A |91 B |91 C |91 D |91 E |91 F

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	Page #
					Total
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					03-03-2014

72/34

74/02

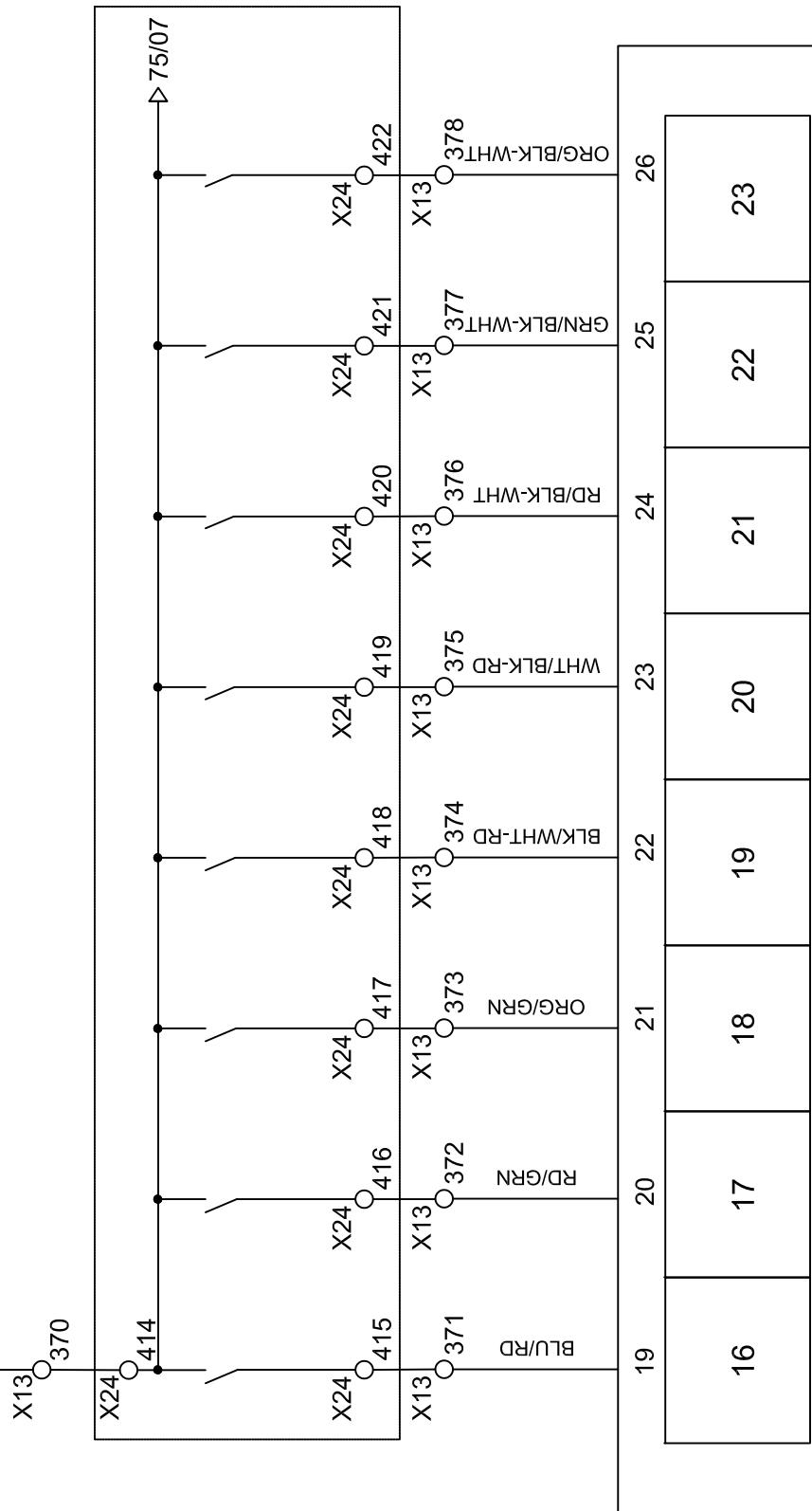


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Allen Bradley 1756-IB32

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73/34

75/02

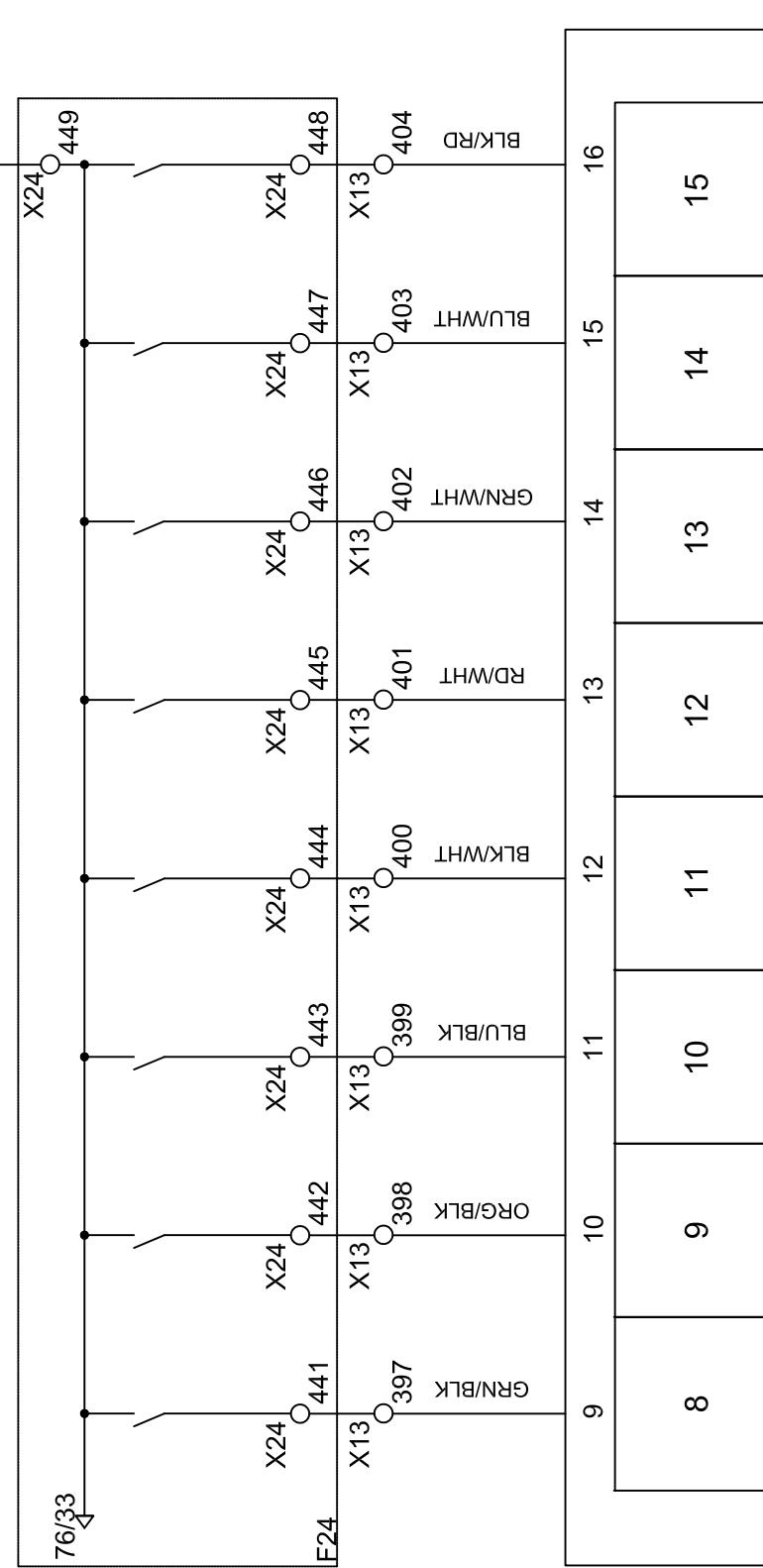


RACK 1 / SLOT 0
Allen Bradley 1756-IB

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			AIR FAN 2 COOLING ZONE (L.S) M1520-33		AIR FAN 3 COOLING ZONE (H.S) M1520-34		AIR FAN 3 COOLING ZONE (L.S) M1520-35		AIR FAN 4 COOLING ZONE (H.S) M1520-35		AIR FAN 4 COOLING ZONE (L.S) M1520-35		AIR FAN 4 COOLING ZONE (H.S) M1520-35																				

76/34 _____ 70/02



RACK 1 / SLOT 1
Allen Bradley 1756-IB32

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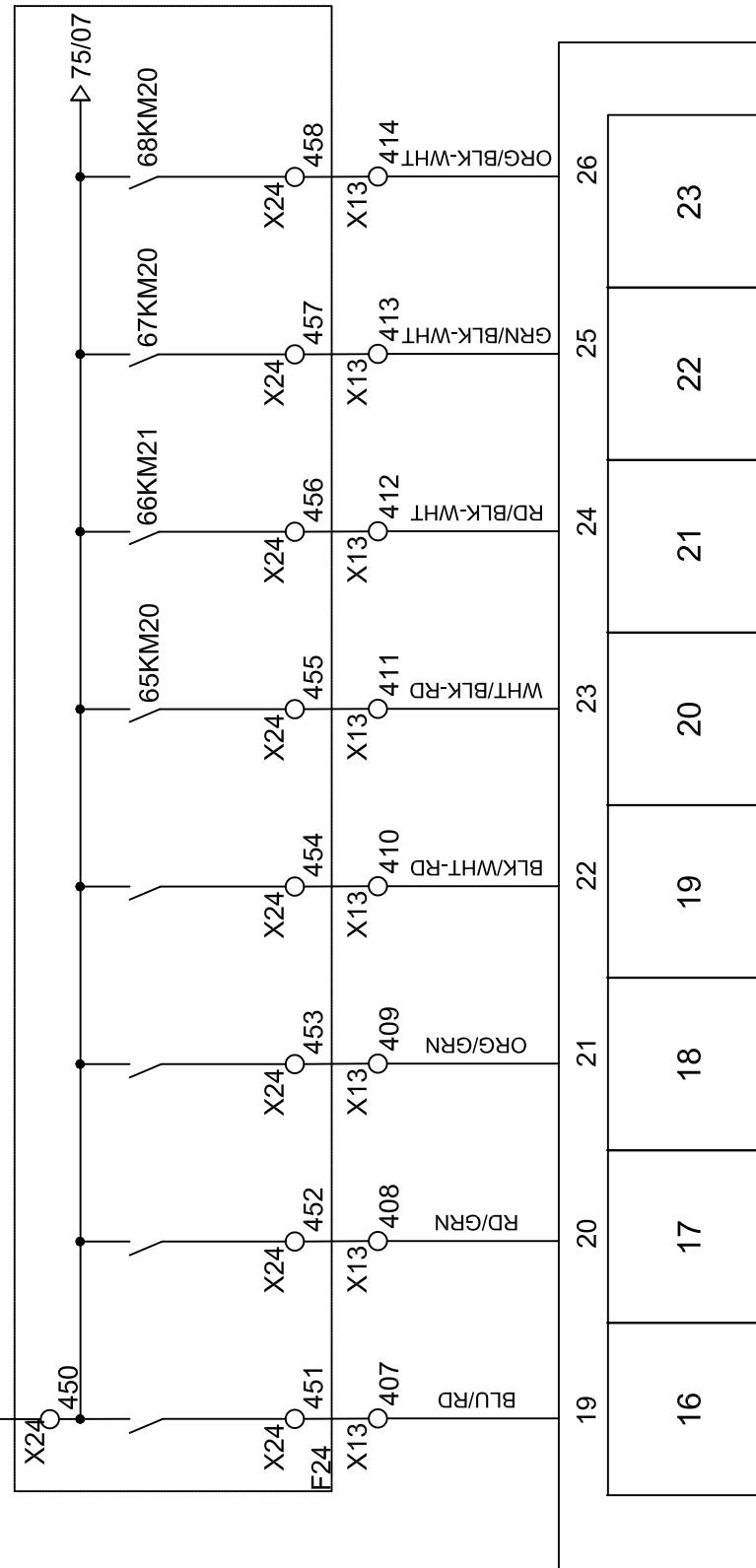
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77/34

79/02



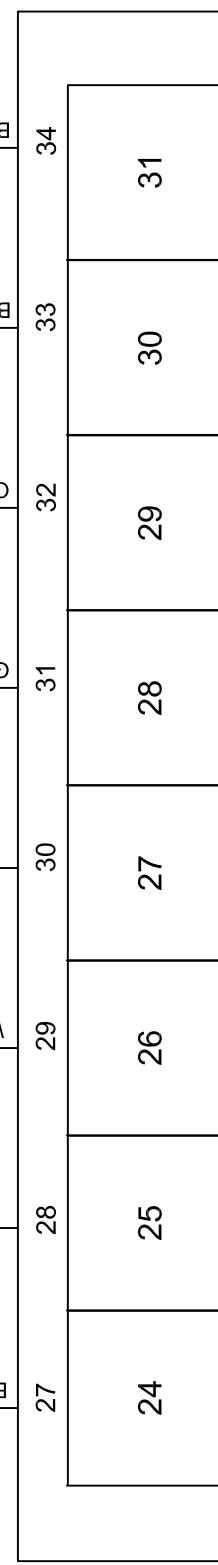
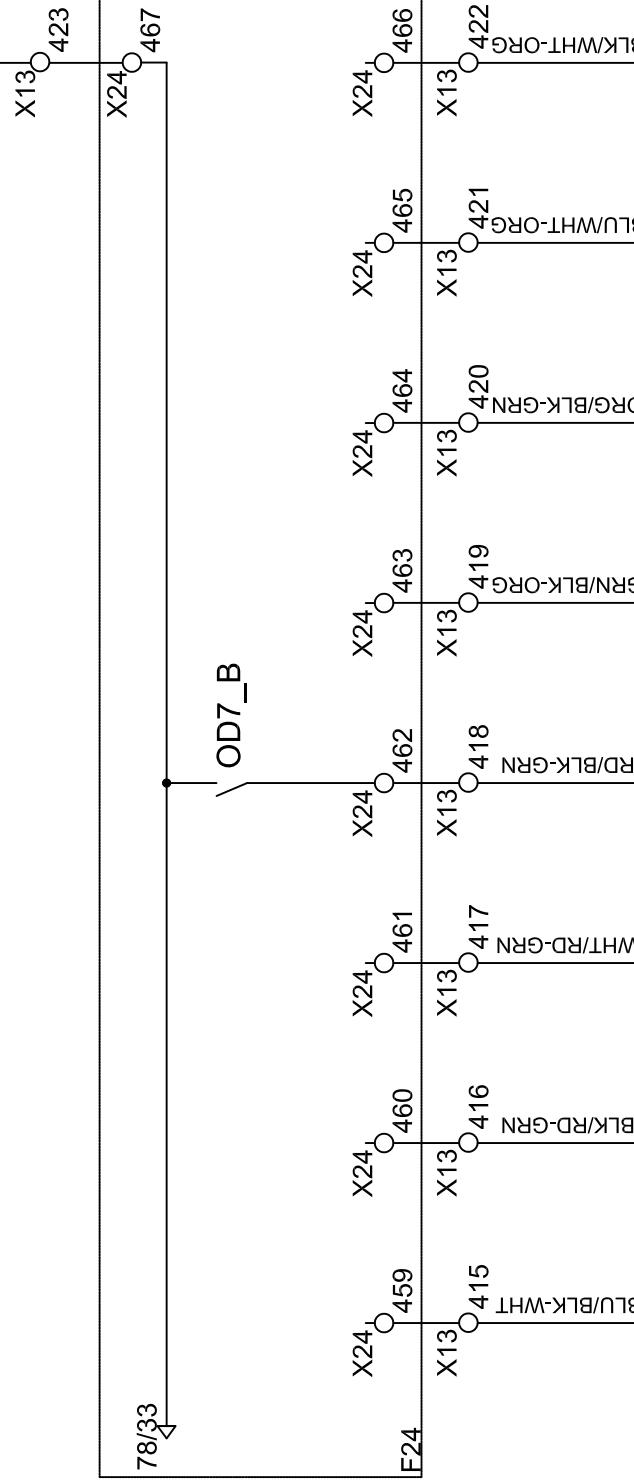
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Allen Bradley 1756-IB

193_0 193_1 193_2 193_3 193_4 193_5 193_6 193_7

32-BIT DIGITAL INPUT

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FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE	

74/34



RACK 1 / SLOT 1
Allen Bradley 1756-IB32

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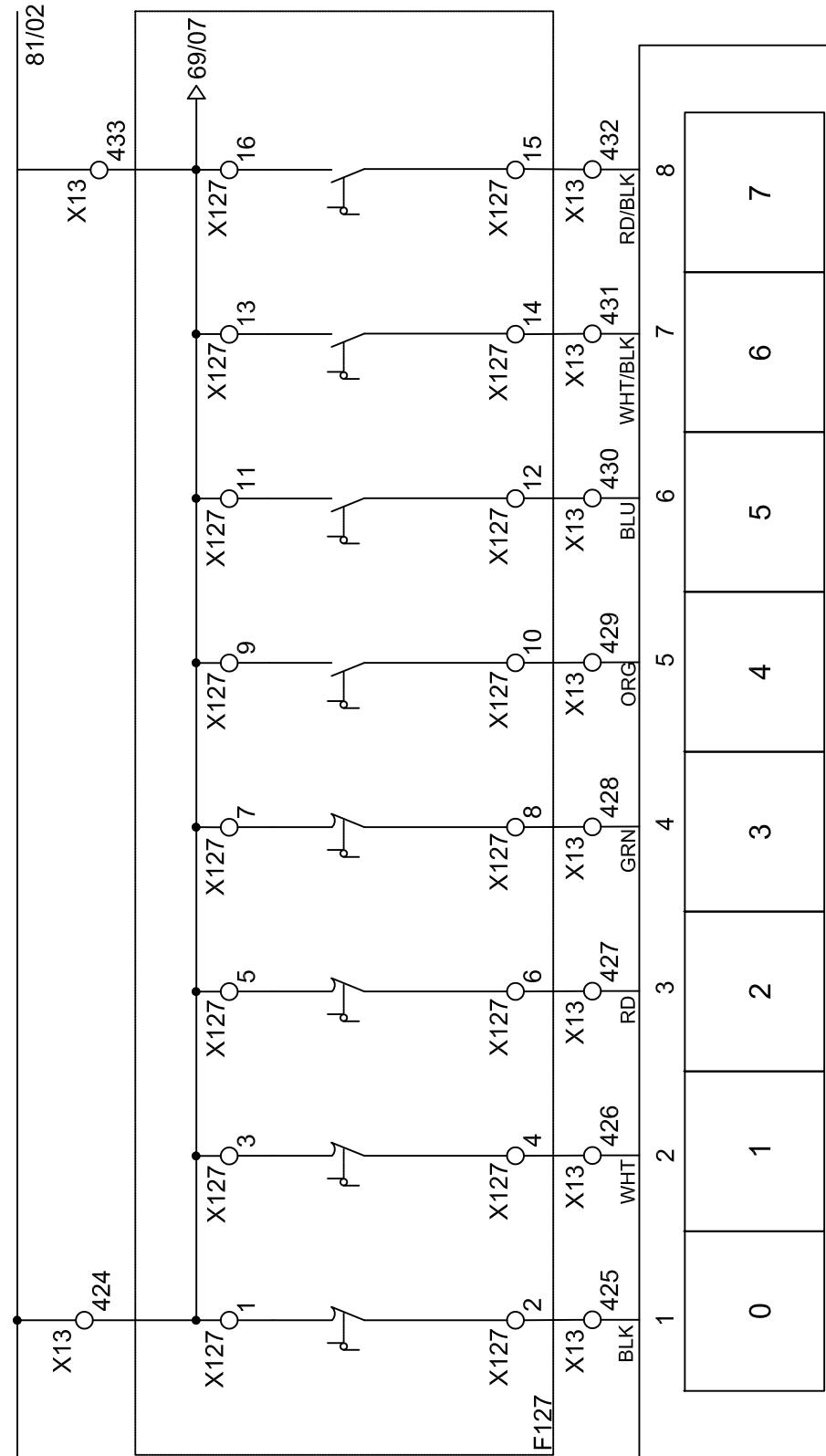
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32 P.L.C. DIGITAL INPUT

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03-03-2014

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2S1301-03	2S1301-04	2S1301-05	2S1301-06	2S1301-05	2S1301-06	2S1301-05	2S1301-06	2S1301-05	2S1301-06	2S1301-05	2S1301-06	2S1301-05	2S1301-06	2S1301-05	2S1301-06	2S1301-05	2S1301-06	2S1301-05	2S1301-06	
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36 GND-1

18 GND-0

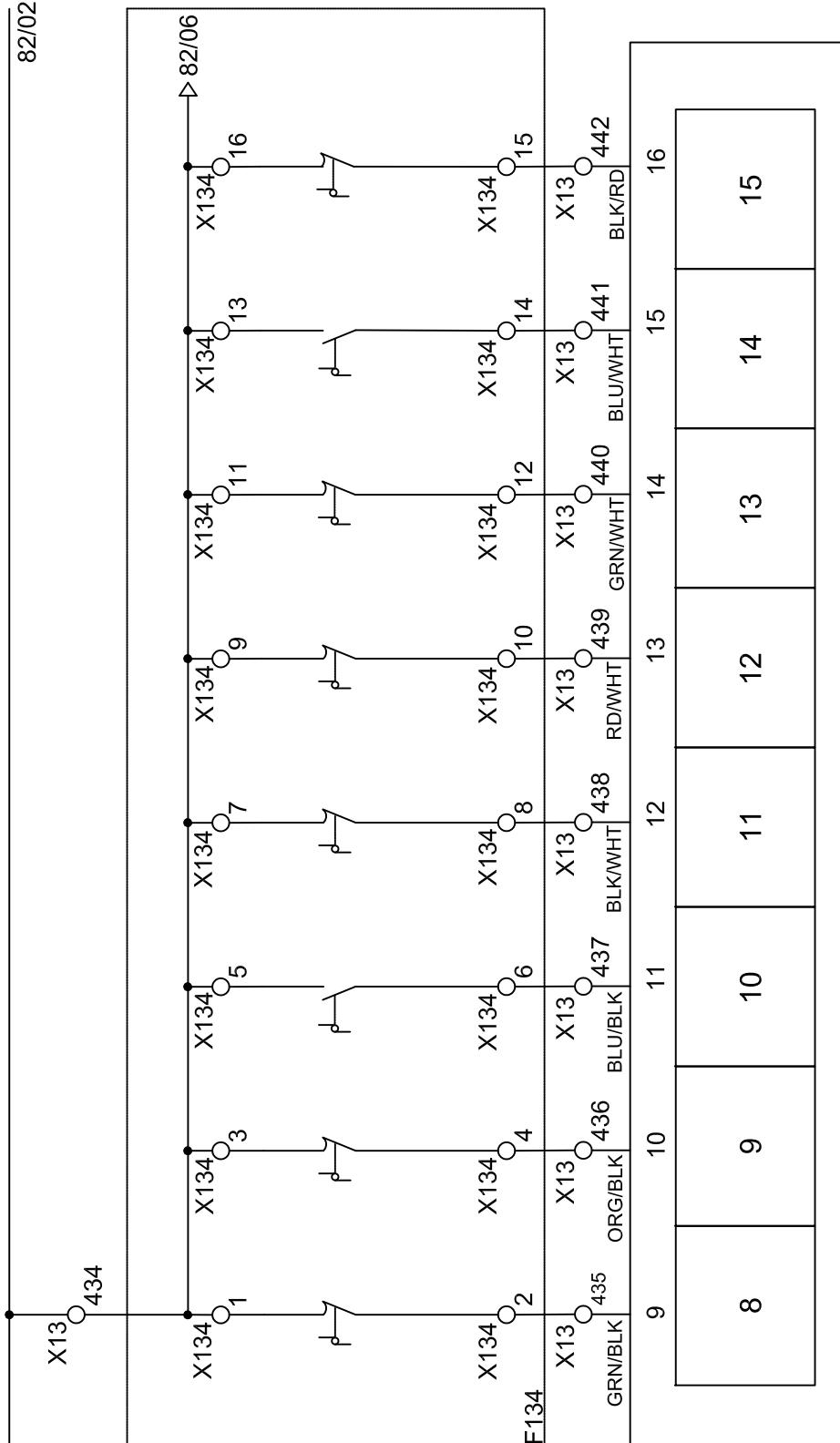
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Allen Bradley 1756-IB

84 0 | 84 1 | 84 2 | 84 3 | 84 4 | 84 5 | 84 6 | 84 7

הנחיות להליכת כבש

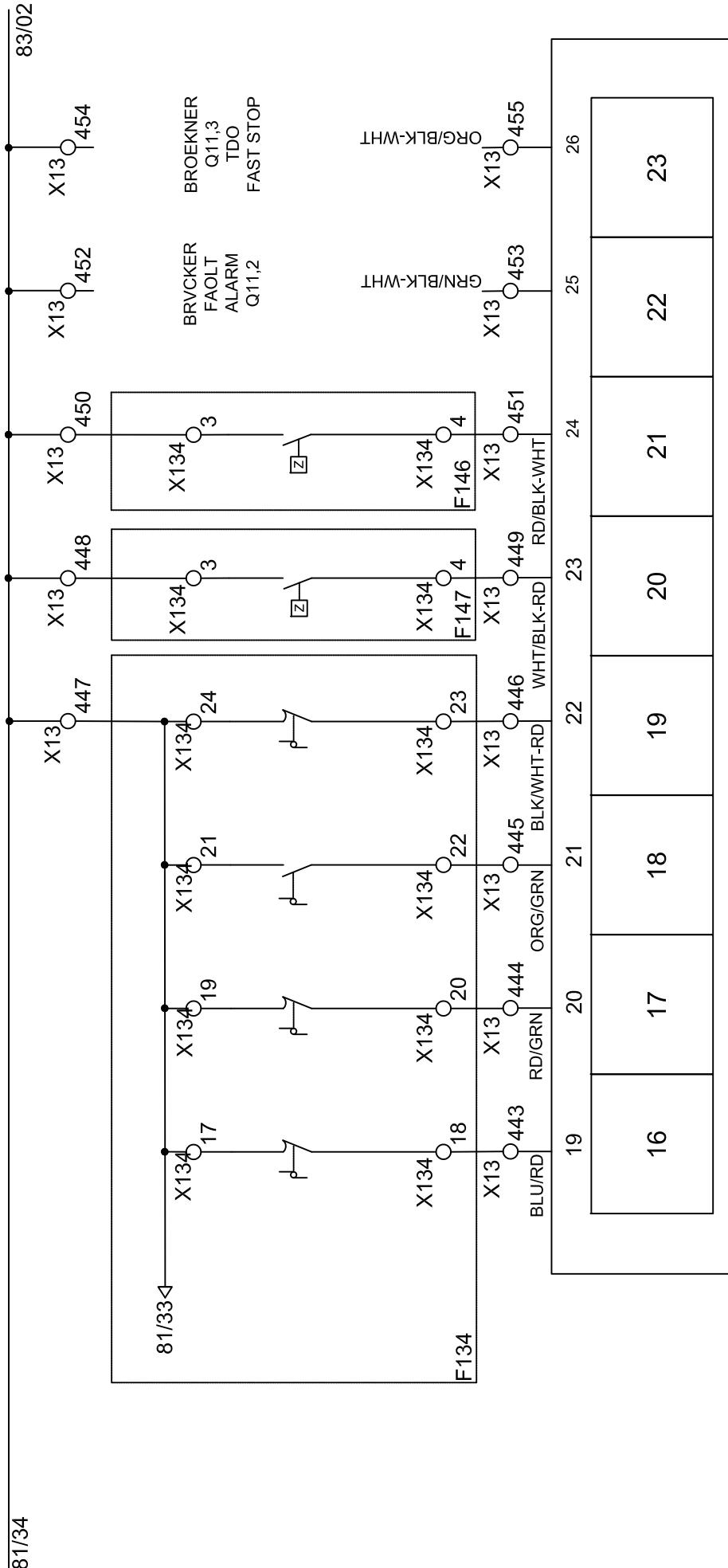
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JEFF LEE	VINCENT HUANG	1	UPGRADE TO AB	Bryan Hong	11/21/2023						MATERIAL

82/02



RACK 1 / SLOT 2
Allen Bradley 1756-IB

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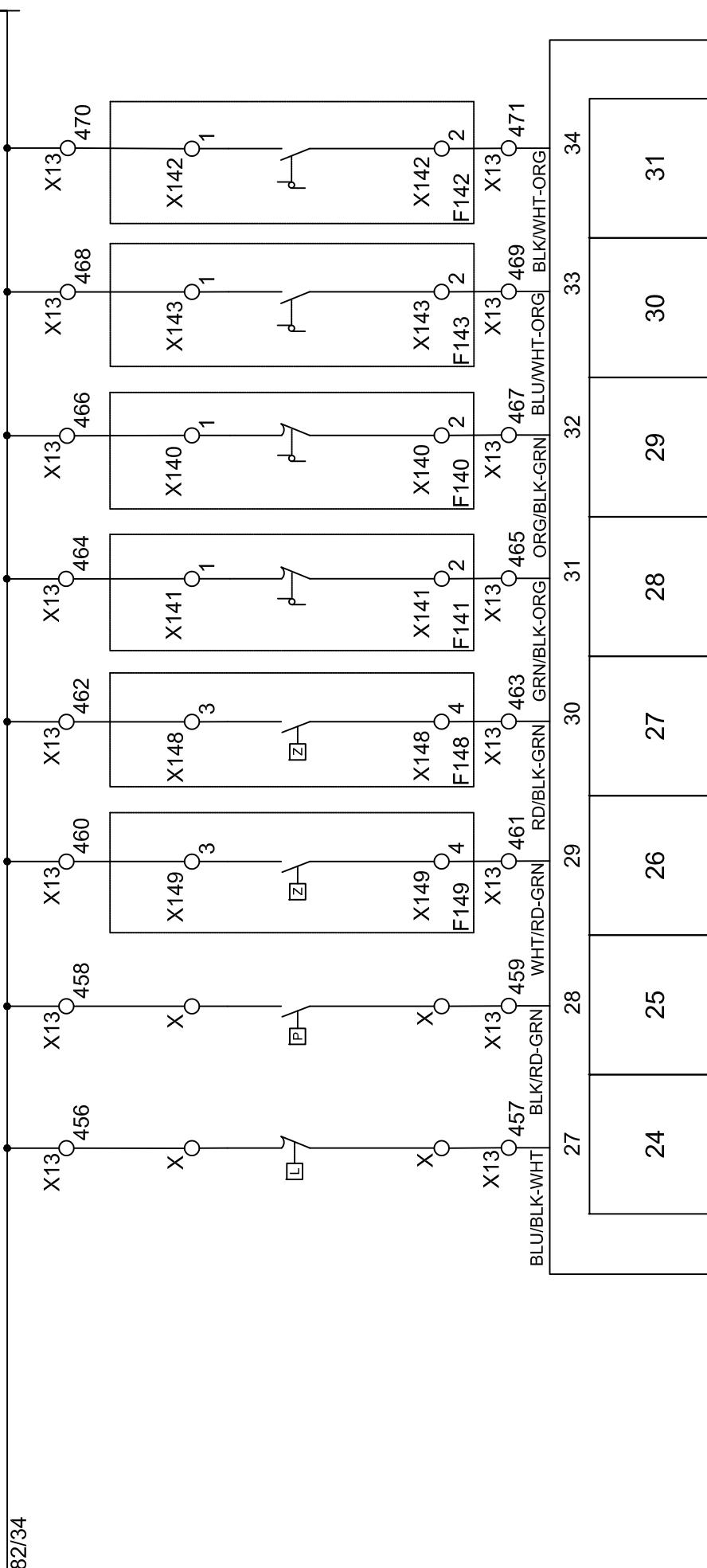
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Allen Bradley 1756-IB:

1940 1941 1942 1943 1944 1945 1946 1947

32 BI & DIGITAL INPUT

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32 P.L.C. DIGITAL INPUT																																	
INTEPLAST GROUP, Ltd.																																	
AMTOPP DIV. M/E DEPT.																																	
																																	
DRAWN BY JEFF LEE																																	
CHECKED BY VINCENT HUANG																																	
REV. NO REV. DESCRIPTION REV. BY: DRAWN DATE: 03-03-2014																																	
1 LINE1 F13 UPGRADE Leo Lin 01/23/2025 Bryan Hong 1/1/21/2023																																	
1 UPGRADE TO AB																																	
DRAFTING NO. MATERIAL																																	
DRAWING DESCRIPTION KF F13																																	
Page # Total																																	
82																																	

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CHAIN TENSION LEVEL	LSL1515-02	CHAIN TENSION PRESSURE	PSL1515-03	WEB BREAK FILM	TDO	WEB BREAK FILM	TDO	DRIVE SIDE TENSION	2S1531-01	DRIVE SIDE TENSION	2S1531-02	OPERATOR SIDE TENSION	2S1515-06	OPERATOR SIDE TENSION	2S1515-07	DRIVE SIDE COUNTER	2S1550-01	OPERATOR SIDE TENSION	2S1550-02	DRIVE SIDE COUNTER	2S1550-01	OPERATOR SIDE TENSION	2S1550-02	OPERATOR SIDE TENSION	2S1550-01	OPERATOR SIDE TENSION	2S1550-02	OPERATOR SIDE TENSION	2S1550-01	OPERATOR SIDE TENSION	2S1550-02	OPERATOR SIDE TENSION	2S1550-01	OPERATOR SIDE TENSION	2S1550-02				
82/34	X13 456	X13 458	X13 460	X13 462	X13 464	X13 466	X13 468	X13 470	X13 460	X13 462	X13 464	X13 466	X13 468	X13 470	X13 461	X13 463	X13 465	X13 467	X13 469	X13 471	X13 461	X13 463	X13 465	X13 467	X13 469	X13 471	X13 461	X13 463	X13 465	X13 467	X13 469	X13 471	X13 461	X13 463	X13 465	X13 467	X13 469	X13 471	
BLU/BLK-WHT	BLK/RD-GRN	WHT/RD-GRN	RD/BLK-GRN	GRN/BLK-ORG	ORG/BLK-GRN	BLU/WHT-ORG	BLK/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG	BLU/WHT-ORG



RACK 1 / SLOT 2

Allen Bradley 1756-IB32

I94_8 I94_9 I94_A I94_B I94_C I94_D I94_E I94_F

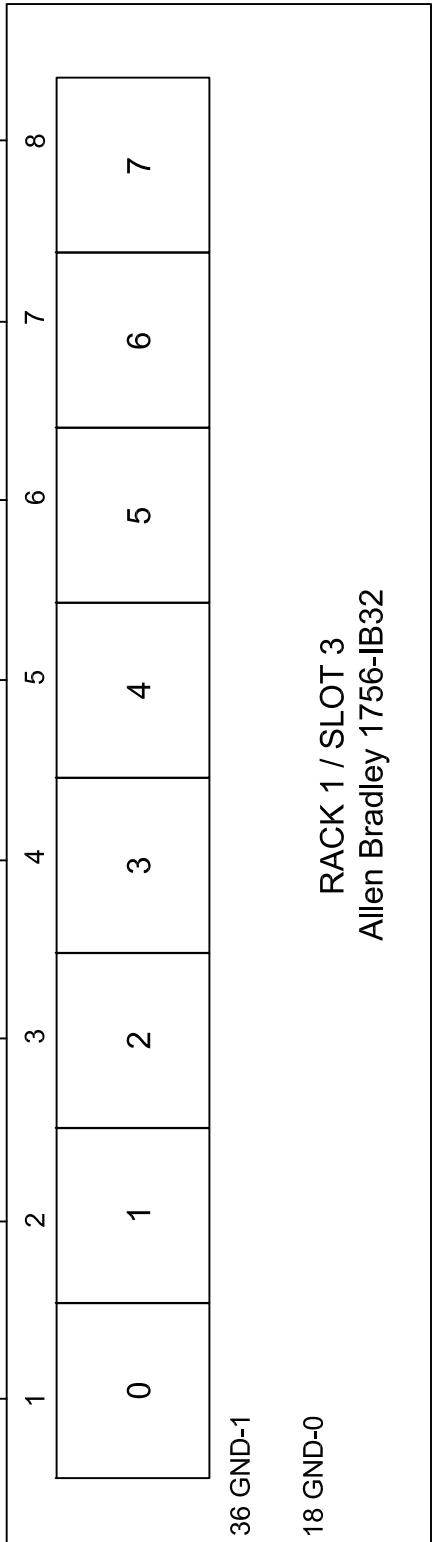
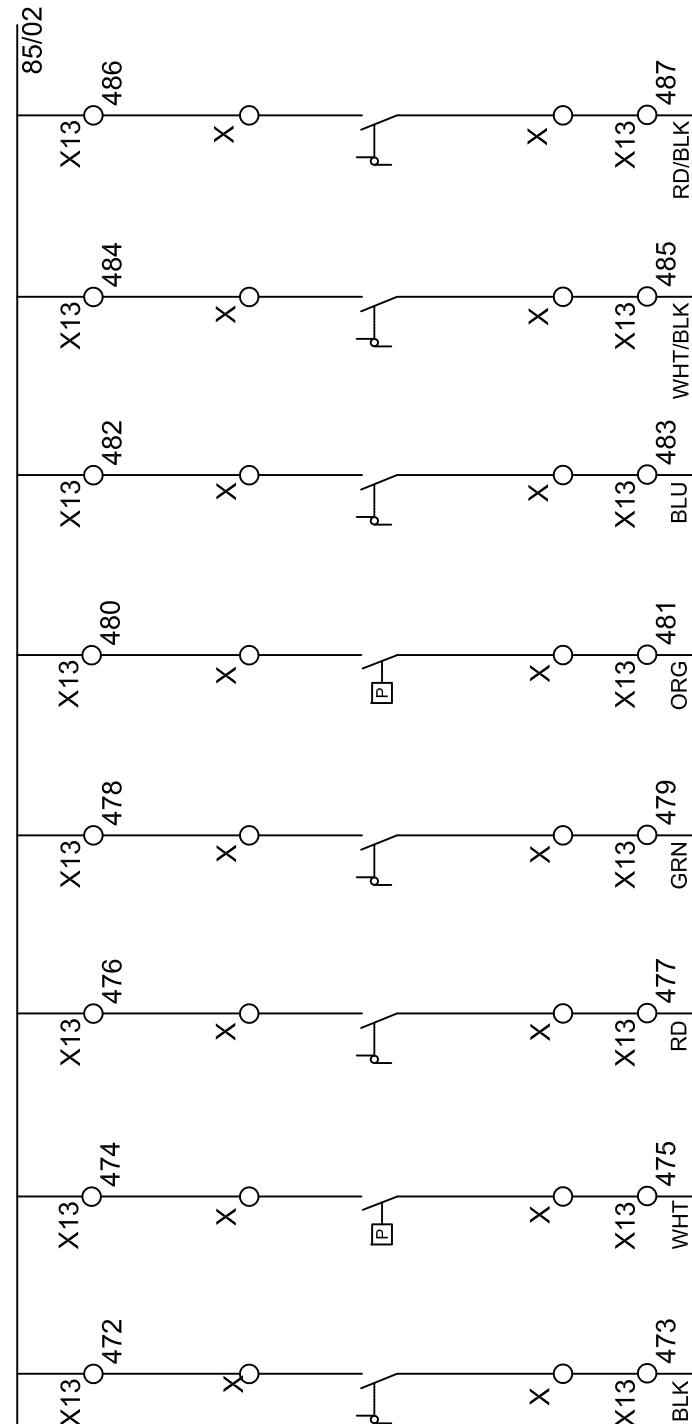
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INTEPLAST GROUP, Ltd. AMTOPP DIV. MIE DEPT.																																				
DRAWN BY	JEFF LEE																																			
CHECKED BY	VINCENT HUANG																																			

32 P.L.C. DIGITAL INPUT

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SCALE	NONE	UNIT	MM				

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COR. ELECTRODE 1 IN POS. 2SH1820.08	COR. ELECTRODE 1 IN POS. PSL1820.09	COR. ELECTRODE 1 IN POS. 2SH1020.10	COR. ELECTRODE 1 IN POS. 2SH1820.12	COR. ELECTRODE 1 IN POS. PSL1820.14	COR. ELECTRODE 3 IN POS. 2SH1820.13	COR. ELECTRODE 3 IN POS. PSL1820.17	COR. ELECTRODE 2 IN POS. 2SL1820.10	COR. ELECTRODE 2 IN POS. 2SL1820.11	COR. ELECTRODE 2 IN POS. 2SL1820.12	COR. ELECTRODE 2 IN POS. 2SL1820.13	COR. ELECTRODE 2 IN POS. 2SL1820.14	COR. ELECTRODE 2 IN POS. 2SL1820.15	COR. ELECTRODE 2 IN POS. 2SL1820.16	COR. ELECTRODE 2 IN POS. 2SL1820.17	COR. ELECTRODE 2 IN POS. 2SL1820.18	COR. ELECTRODE 2 IN POS. 2SL1820.19	COR. ELECTRODE 2 IN POS. 2SL1820.20	COR. ELECTRODE 2 IN POS. 2SL1820.21	COR. ELECTRODE 2 IN POS. 2SL1820.22	COR. ELECTRODE 2 IN POS. 2SL1820.23	COR. ELECTRODE 2 IN POS. 2SL1820.24	COR. ELECTRODE 2 IN POS. 2SL1820.25	COR. ELECTRODE 2 IN POS. 2SL1820.26	COR. ELECTRODE 2 IN POS. 2SL1820.27	COR. ELECTRODE 2 IN POS. 2SL1820.28	COR. ELECTRODE 2 IN POS. 2SL1820.29	COR. ELECTRODE 2 IN POS. 2SL1820.30	COR. ELECTRODE 2 IN POS. 2SL1820.31	COR. ELECTRODE 2 IN POS. 2SL1820.32	COR. ELECTRODE 2 IN POS. 2SL1820.33	COR. ELECTRODE 2 IN POS. 2SL1820.34	COR. ELECTRODE 2 IN POS. 2SL1820.35	COR. ELECTRODE 2 IN POS. 2SL1820.36	COR. ELECTRODE 2 IN POS. 2SL1820.37	COR. ELECTRODE 2 IN POS. 2SL1820.38	COR. ELECTRODE 2 IN POS. 2SL1820.39	COR. ELECTRODE 2 IN POS. 2SL1820.40	COR. ELECTRODE 2 IN POS. 2SL1820.41	COR. ELECTRODE 2 IN POS. 2SL1820.42	COR. ELECTRODE 2 IN POS. 2SL1820.43	COR. ELECTRODE 2 IN POS. 2SL1820.44	COR. ELECTRODE 2 IN POS. 2SL1820.45	COR. ELECTRODE 2 IN POS. 2SL1820.46	COR. ELECTRODE 2 IN POS. 2SL1820.47	COR. ELECTRODE 2 IN POS. 2SL1820.48	COR. ELECTRODE 2 IN POS. 2SL1820.49	COR. ELECTRODE 2 IN POS. 2SL1820.50	COR. ELECTRODE 2 IN POS. 2SL1820.51	COR. ELECTRODE 2 IN POS. 2SL1820.52	COR. ELECTRODE 2 IN POS. 2SL1820.53	COR. ELECTRODE 2 IN POS. 2SL1820.54	COR. ELECTRODE 2 IN POS. 2SL1820.55	COR. ELECTRODE 2 IN POS. 2SL1820.56	COR. ELECTRODE 2 IN POS. 2SL1820.57	COR. ELECTRODE 2 IN POS. 2SL1820.58	COR. ELECTRODE 2 IN POS. 2SL1820.59	COR. ELECTRODE 2 IN POS. 2SL1820.60	COR. ELECTRODE 2 IN POS. 2SL1820.61	COR. ELECTRODE 2 IN POS. 2SL1820.62	COR. ELECTRODE 2 IN POS. 2SL1820.63	COR. ELECTRODE 2 IN POS. 2SL1820.64	COR. ELECTRODE 2 IN POS. 2SL1820.65	COR. ELECTRODE 2 IN POS. 2SL1820.66	COR. ELECTRODE 2 IN POS. 2SL1820.67	COR. ELECTRODE 2 IN POS. 2SL1820.68	COR. ELECTRODE 2 IN POS. 2SL1820.69	COR. ELECTRODE 2 IN POS. 2SL1820.70	COR. ELECTRODE 2 IN POS. 2SL1820.71	COR. ELECTRODE 2 IN POS. 2SL1820.72	COR. ELECTRODE 2 IN POS. 2SL1820.73	COR. ELECTRODE 2 IN POS. 2SL1820.74	COR. ELECTRODE 2 IN POS. 2SL1820.75	COR. ELECTRODE 2 IN POS. 2SL1820.76	COR. ELECTRODE 2 IN POS. 2SL1820.77	COR. ELECTRODE 2 IN POS. 2SL1820.78	COR. ELECTRODE 2 IN POS. 2SL1820.79	COR. ELECTRODE 2 IN POS. 2SL1820.80	COR. ELECTRODE 2 IN POS. 2SL1820.81	COR. ELECTRODE 2 IN POS. 2SL1820.82	COR. ELECTRODE 2 IN POS. 2SL1820.83	COR. ELECTRODE 2 IN POS. 2SL1820.84	COR. ELECTRODE 2 IN POS. 2SL1820.85	COR. ELECTRODE 2 IN POS. 2SL1820.86	COR. ELECTRODE 2 IN POS. 2SL1820.87	COR. ELECTRODE 2 IN POS. 2SL1820.88	COR. ELECTRODE 2 IN POS. 2SL1820.89	COR. ELECTRODE 2 IN POS. 2SL1820.90	COR. ELECTRODE 2 IN POS. 2SL1820.91	COR. ELECTRODE 2 IN POS. 2SL1820.92	COR. ELECTRODE 2 IN POS. 2SL1820.93	COR. ELECTRODE 2 IN POS. 2SL1820.94	COR. ELECTRODE 2 IN POS. 2SL1820.95	COR. ELECTRODE 2 IN POS. 2SL1820.96	COR. ELECTRODE 2 IN POS. 2SL1820.97	COR. ELECTRODE 2 IN POS. 2SL1820.98	COR. ELECTRODE 2 IN POS. 2SL1820.99	COR. ELECTRODE 2 IN POS. 2SL1820.100

24 VDC / 12Q13
12/13



0 VDC
12/13

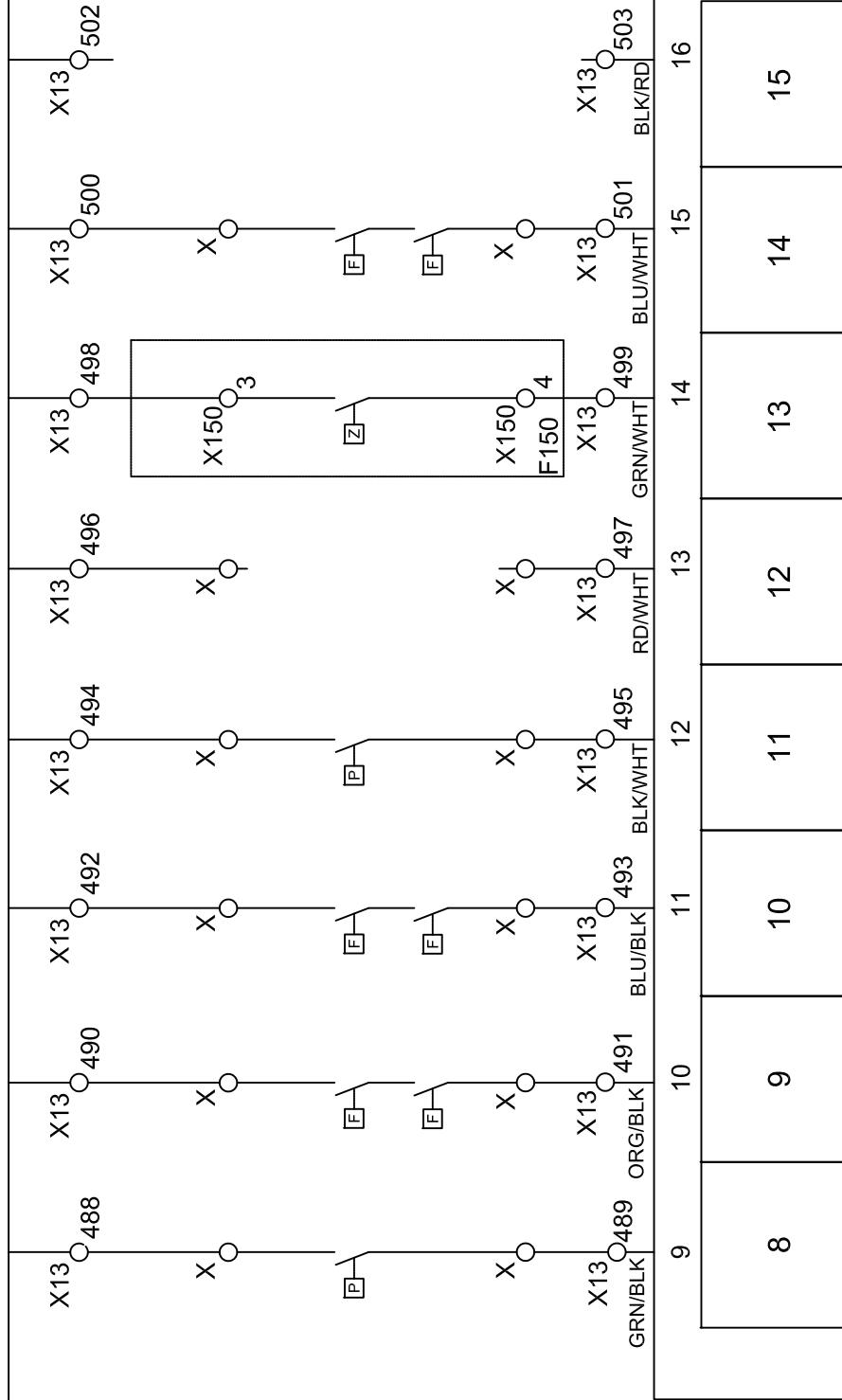
ORG/WHT-BLU
ORG/RD
36 GND-1
18 GND-0

I85_0 I85_1 I85_2 I85_3 I85_4 I85_5 I85_6 I85_7

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COR.	XTRAC.FLOW NUM.1	XTRAC.FLOW NUM.1	XTRAC.FLOW NUM.3	AUX. WINDER 3	FREE	WEB BREAK DETECTOR PRS	EXTRAC.FLOW NUM.2	FREE																										
ELECTRODE 2 PRESSURE	FSL1831-06	FSL1831-07	PSL1860																															
PSL1820-19																													ZT1840-10	ZT1840-08				

34/34

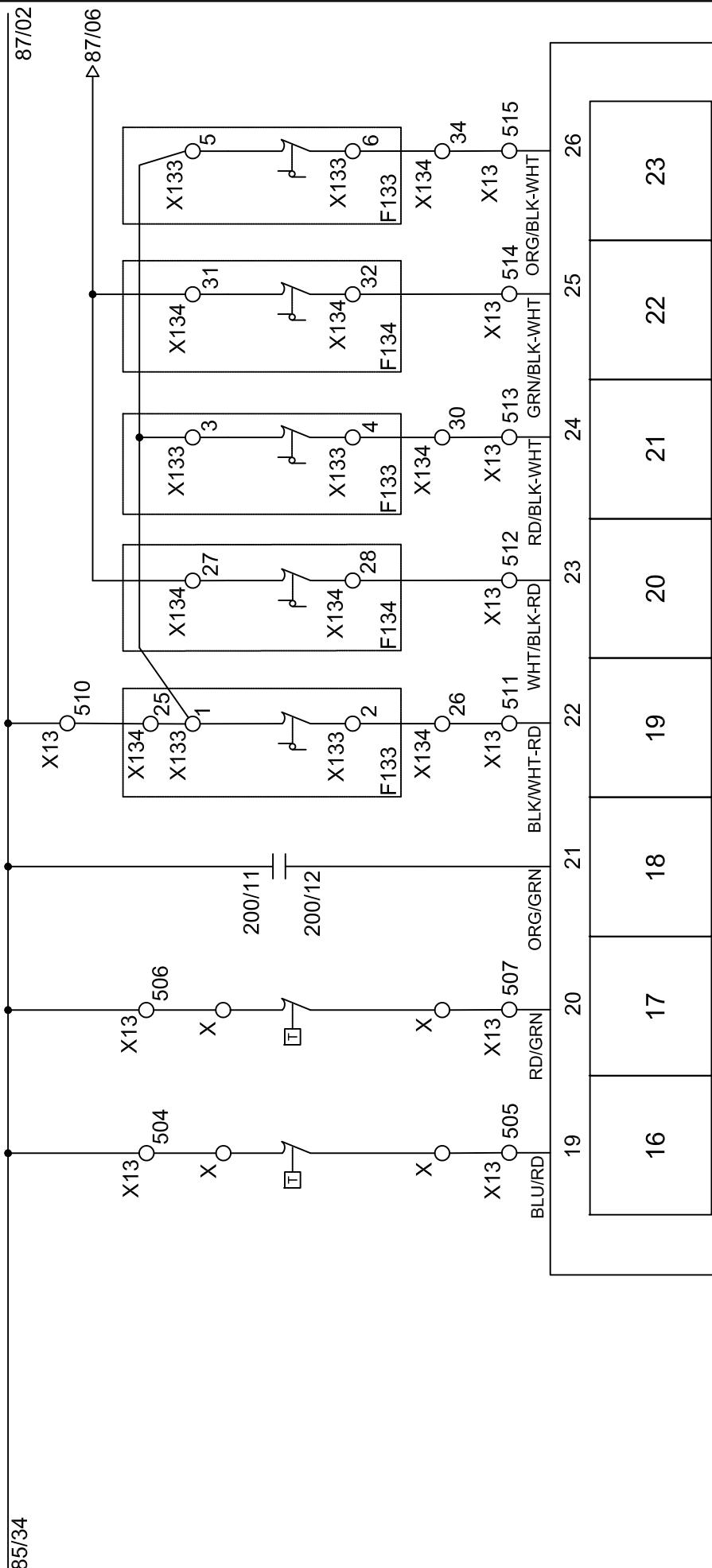


RACK 1 / SLOT 3
Allen Bradley 1756-IB

185 F
185 E
185 D
185 C
185 B
185 A
185 9
185 8

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INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.																																	
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CHEECKED BY VINCENT HUANG																																	
REV. NO 1 UPGRADE TO AB																																	
REV. DATE 11/22/2023 DRAWING NO. Bryan Hong																																	
REV. BY: KF F13 DRAWING DESCRIPTION																																	
DRAWN DATE: 03-03-2014 SCALE: None MATERIAL: M																																	
Page # 85 Total																																	

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AUX. WINDER 1	AUX. WINDER 2	WATER LEVEL						NIP ROLL 1	NIP ROLL 2	NIP ROLL 3																							
TEMP SH1360-03	TEMP SH1450-03	BATH LEVEL LSL1350-03						IN POS.	IN POS.	IN POS.																							



RACK 1 / SLOT 3
Allen Bradley 1756-IB32

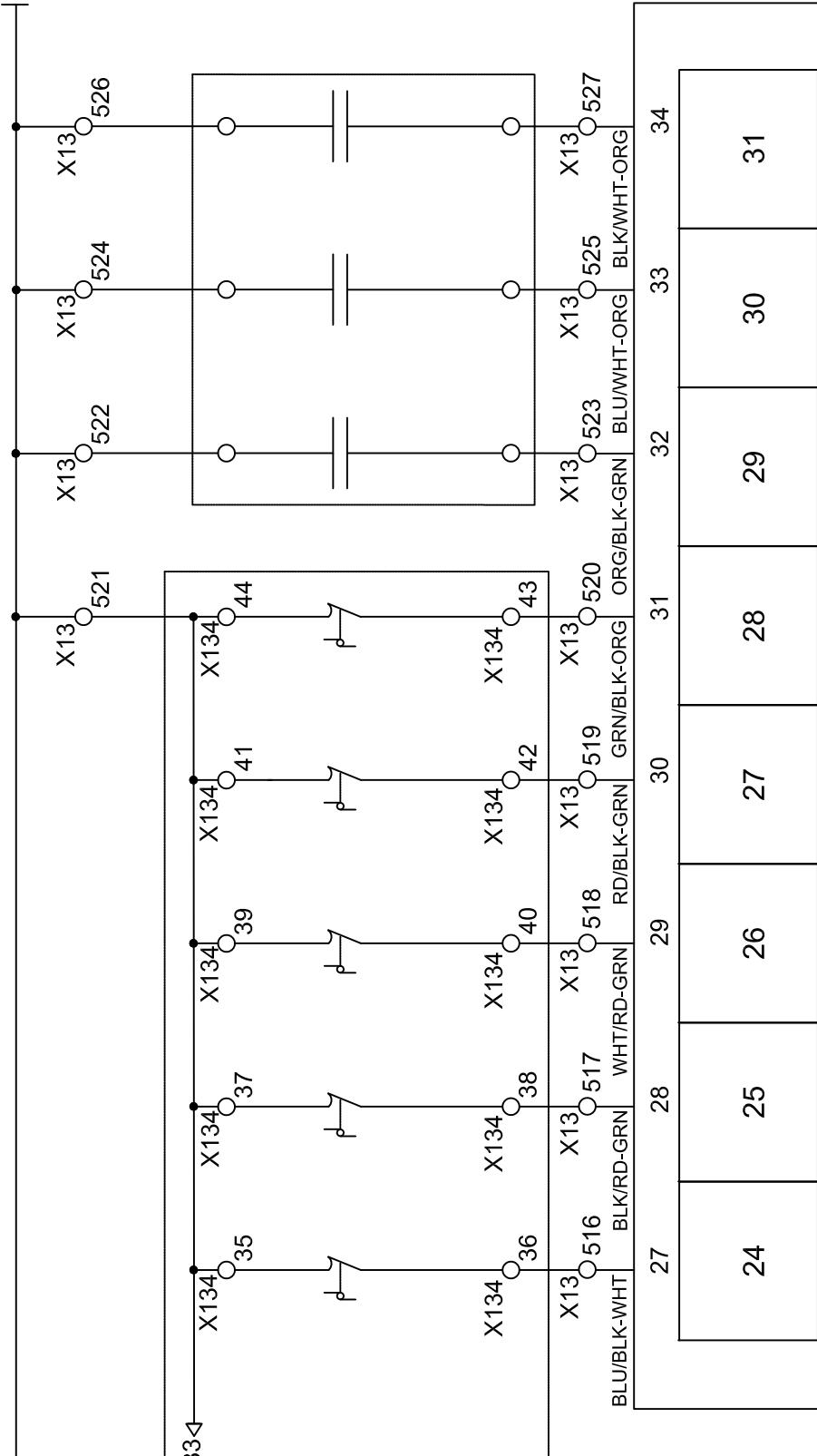
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32 P.L.C. DIGITAL INPUT



INTEPLAST GROUP, Ltd.
AMTOPP DIV., MIE DEPT.

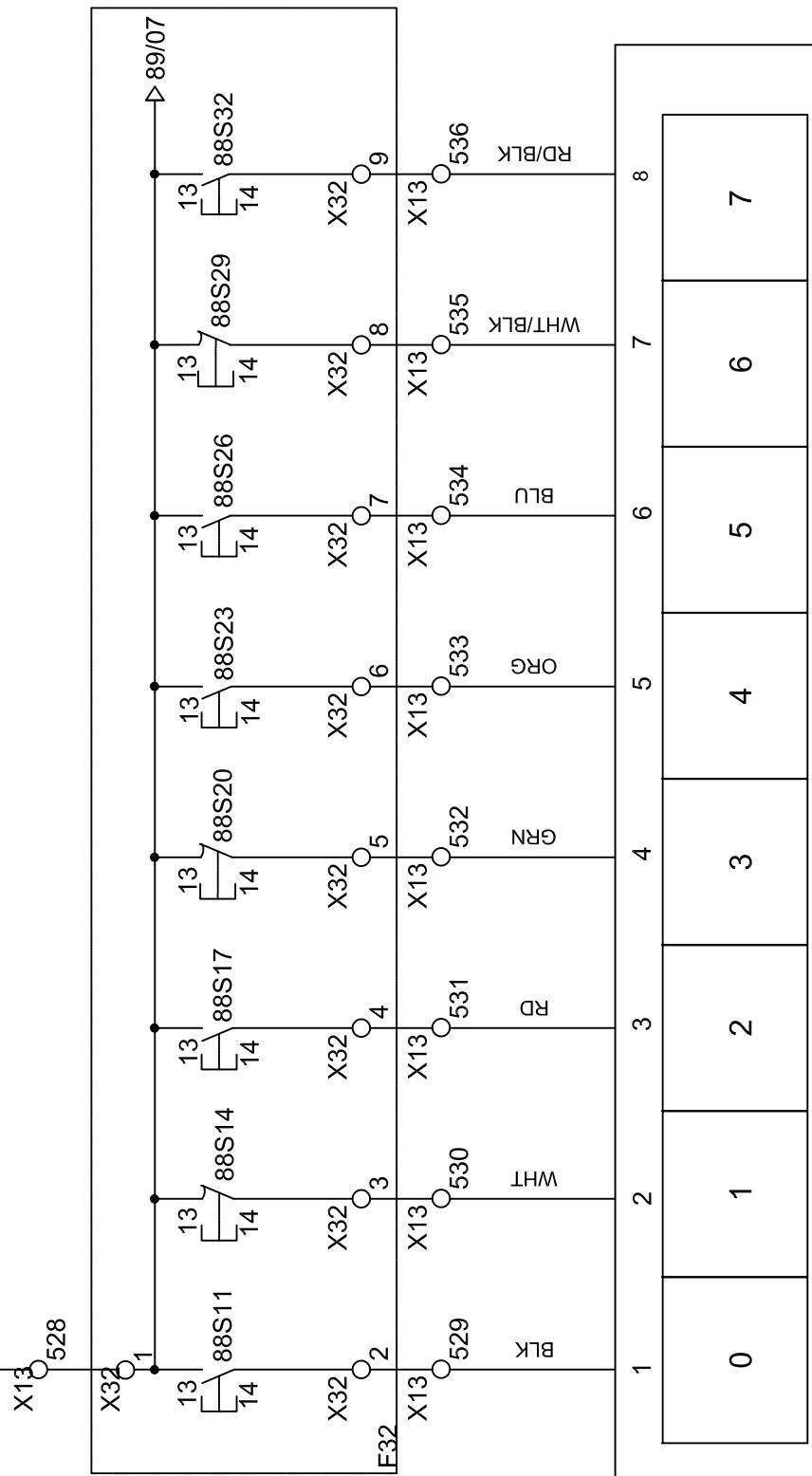


RACK 1 / SLOT 3
Allen Bradley 1756-IB

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EXHAUST HOOD-START	HOOD-STOP													EDGGE PINNING-START	EDGGE PINNING-STOP	C.R. FORWARD	C.R. BACKWARD	C.R. STOP	AIR KNIFF-ENGAGE														

24 VDC / 12Q15
12/15

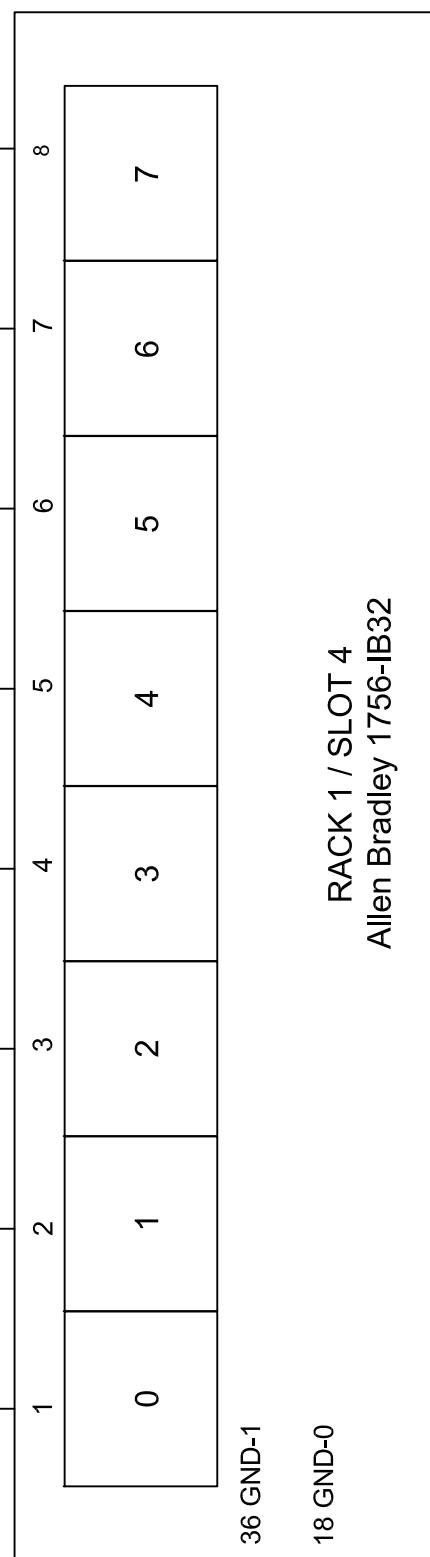
89/02



0 VDC
12/15 ORG/WHT-BLU

36 GND-1
18 GND-0

RACK 1 / SLOT 4
Allen Bradley 1756-IB32



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DRAWN BY	JEFF LEE				
CHECKED BY	VINCENT HUANG				

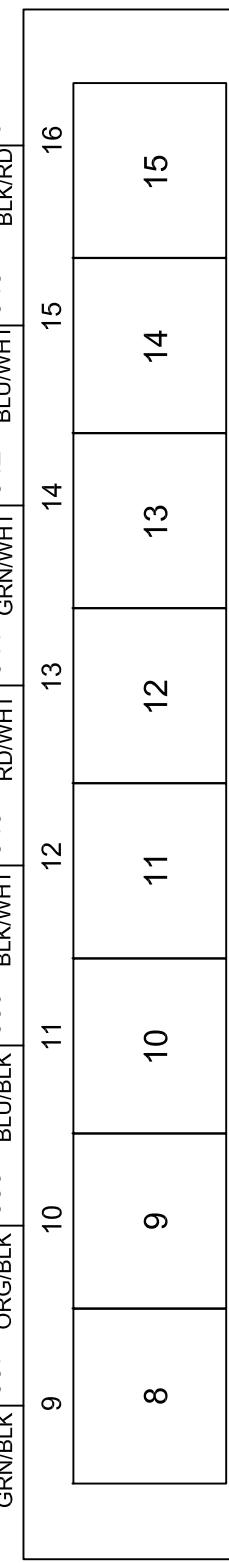
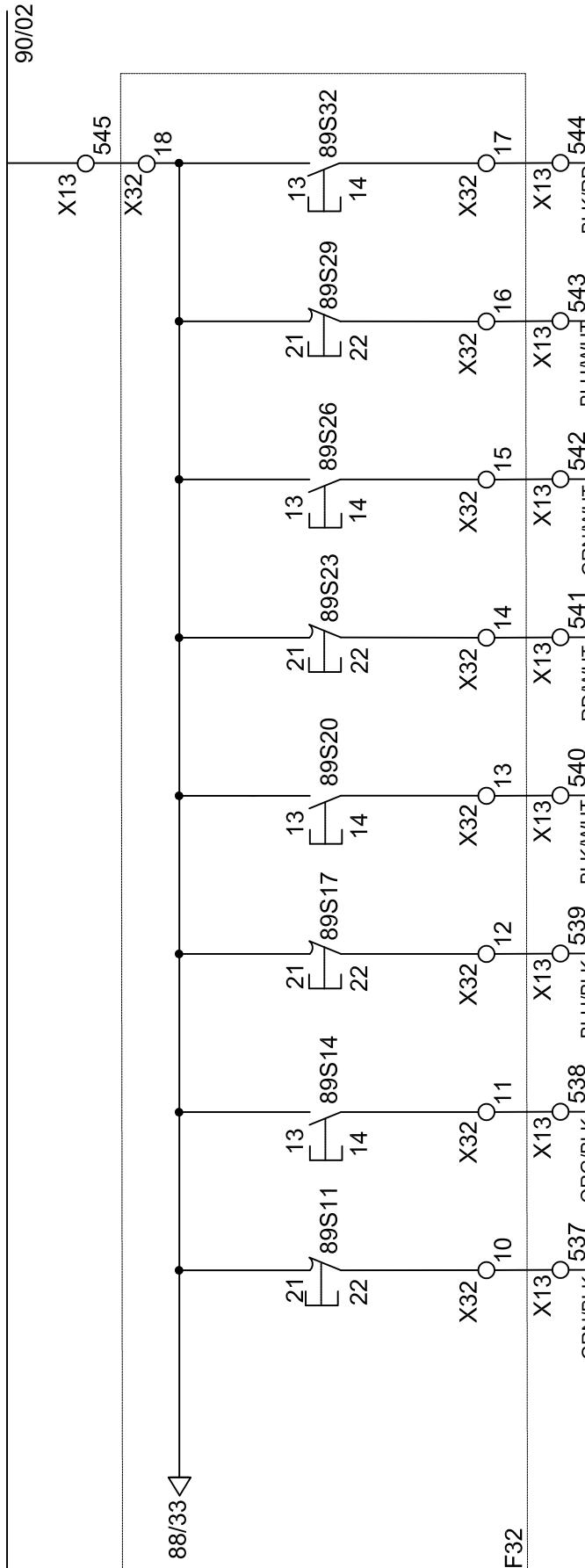
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						SCALE	None	UNIT MM

03-03-2014

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AIR KNIFF RETRACT	AIR KNIFF BLOWER-START	AIR KNIFF BLOWER-STOP	FILM REMOVAL POS.ENG.	FILM REMOVAL POS.RETR	RUBBER ROLL-ENG	RUBBER ROLL-RET.	CHROMED ROLL-ENG																										

88/34



RACK 1 / SLOT 4
Allen Bradley 1756-IB32

I86_8 I86_9 I86_A I86_B I86_C I86_D I86_E I86_F

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INTEPLAST GROUP, Ltd.
AMTOPP DIVI, MIE DEPT.

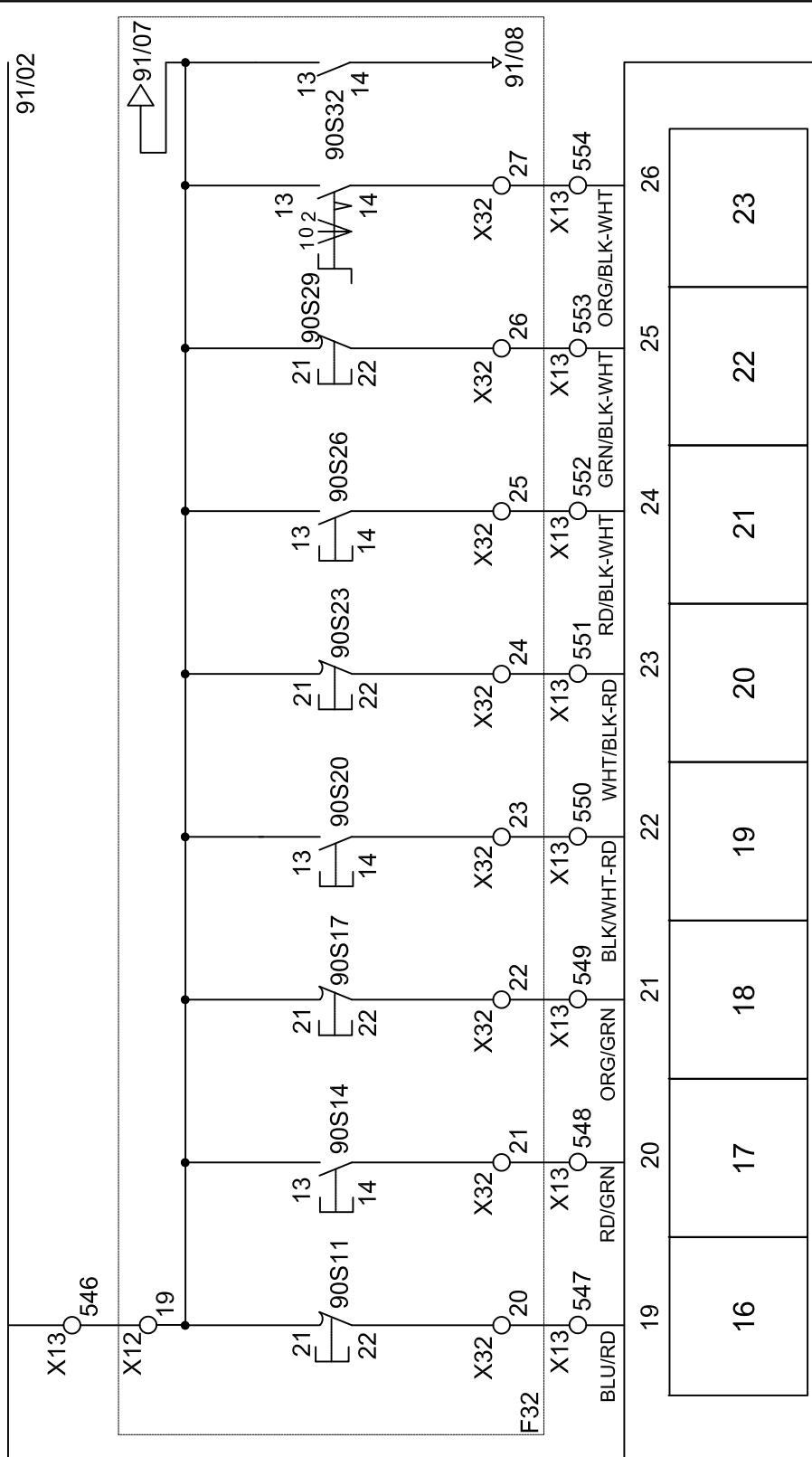
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CHROMED ROLL-RETR.	C.R. WATER REMOVAL-START															FILM WATER REMOVAL-STOP	FILM WATER PREMOVAL-START																

89/34 91/02



RACK 1 / SLOT 4

Allen Bradley 1756-IB32

I96_0 I96_1 I96_2 I96_3 I96_4 I96_5 I96_6 I96_7

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32 P.L.C. DIGITAL INPUT																																			
DRAWN BY	JEFF LEE																																		
CHECKED BY	VINCENT HUANG																																		
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INTEPLAST GROUP, Ltd.
AMTOPP DIVI. MIE DEPT.

DRAWN BY JEFF LEE
CHECKED BY VINCENT HUANG

03-03-2014 DRAWN DATE:
03-03-2014 REV. DATE

03-03-2014 REV. NO.

03-03-2014 REV. DESCRIPTION

03-03-2014 REV. BY:

03-03-2014 REV. DATE

03-03-2014 DRAWN NO.

03-03-2014 DRAWING DESCRIPTION

03-03-2014 KF

03-03-2014 F13

03-03-2014 Page #

03-03-2014 Total

03-03-2014 MATERIAL

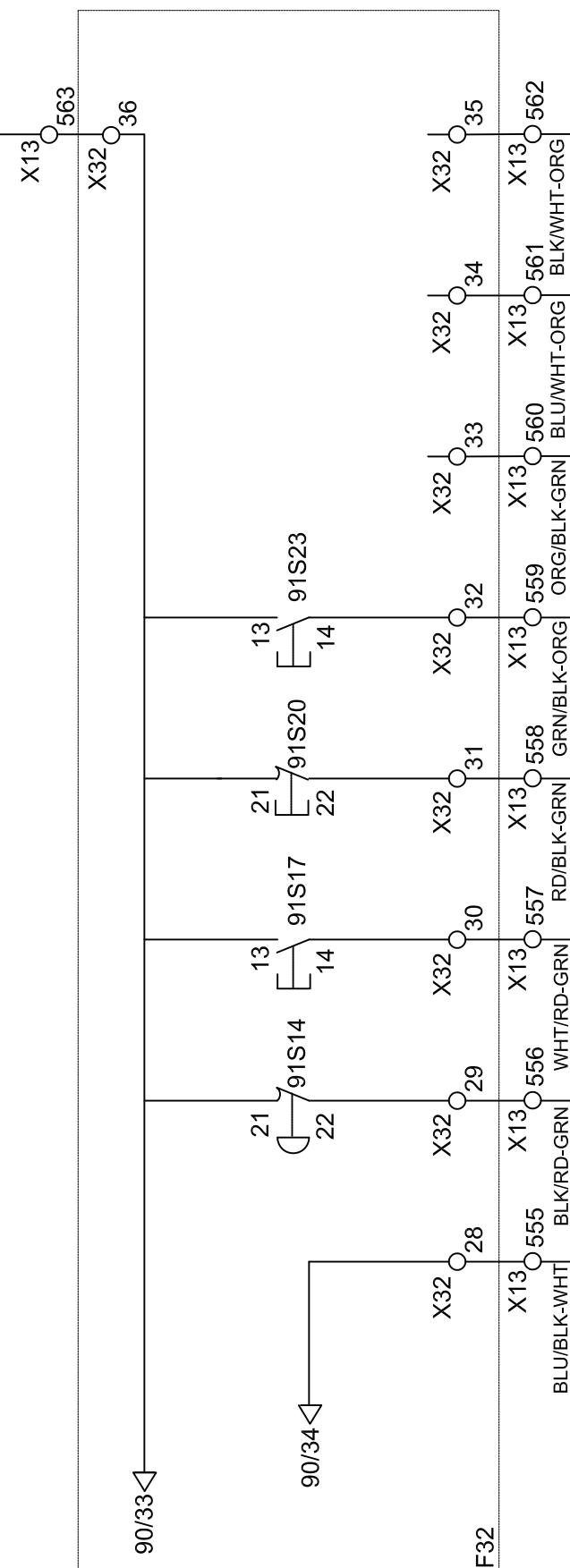
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03-03-2014 UNIT

03-03-2014 MM

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90/34



27	28	29	30	31	32	33	34
24	25	26	27	28	29	30	31

RACK 1 / SLOT 4

Allen Bradley 1756-IB32

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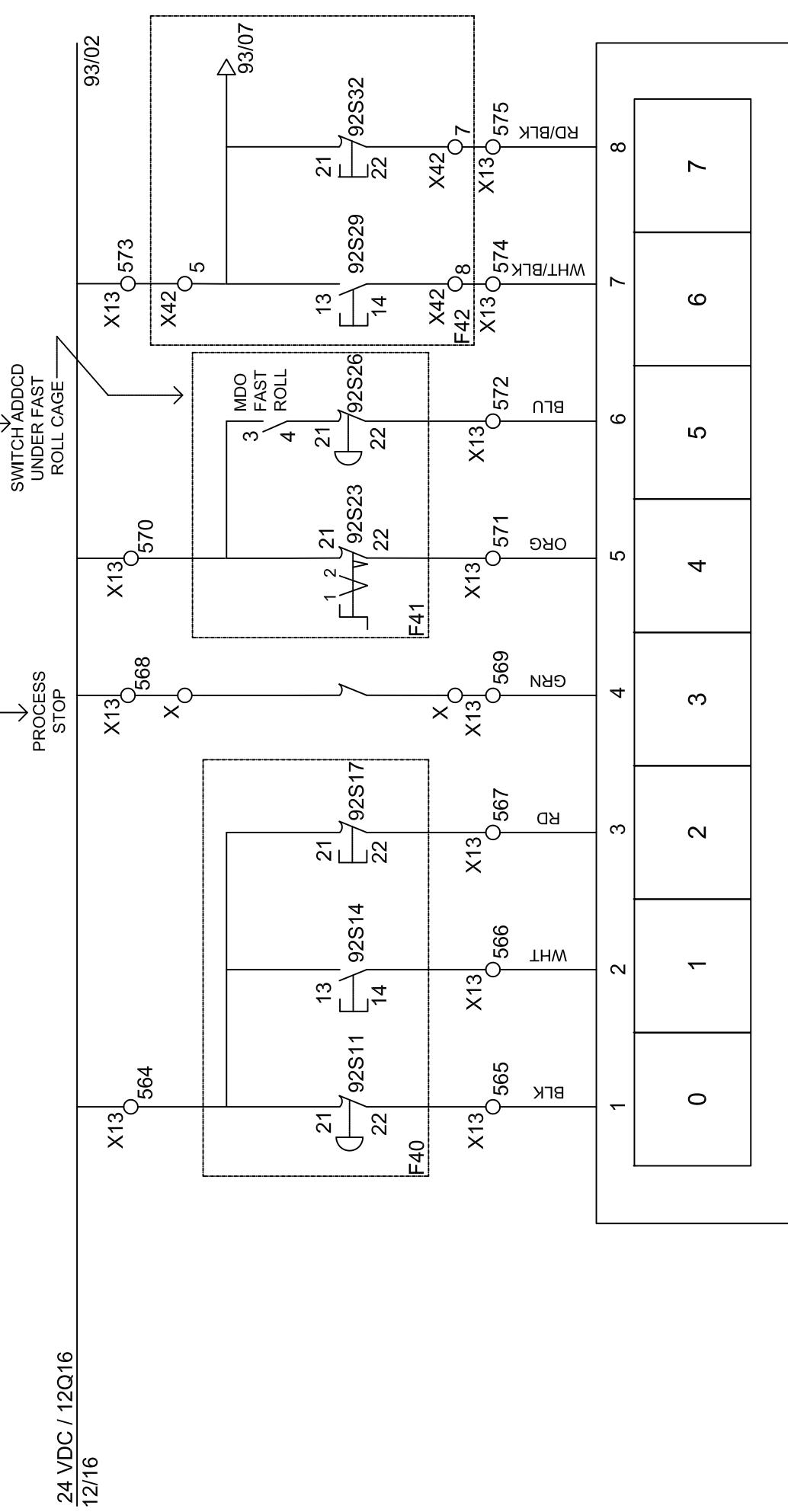
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						SCALE		
						UNIT		
						MM		



INTEPLAST GROUP, Ltd.
AMTOPP DIVI, MIE DEPT.

DRAWN BY JEFF LEE

CHECKED BY VINCENT HUANG



U VDC		36 GND-1
12/16	ORG/WHT-BLU ORG/RD	18 GND-0

RACK 1 / SLOT 5
Allen Bradley 1756-IB

|87_0 |87_1 |87_2 |87_3 |87_4 |87_5 |87_6 |87_7

32 | C. DIGITAL INPUT

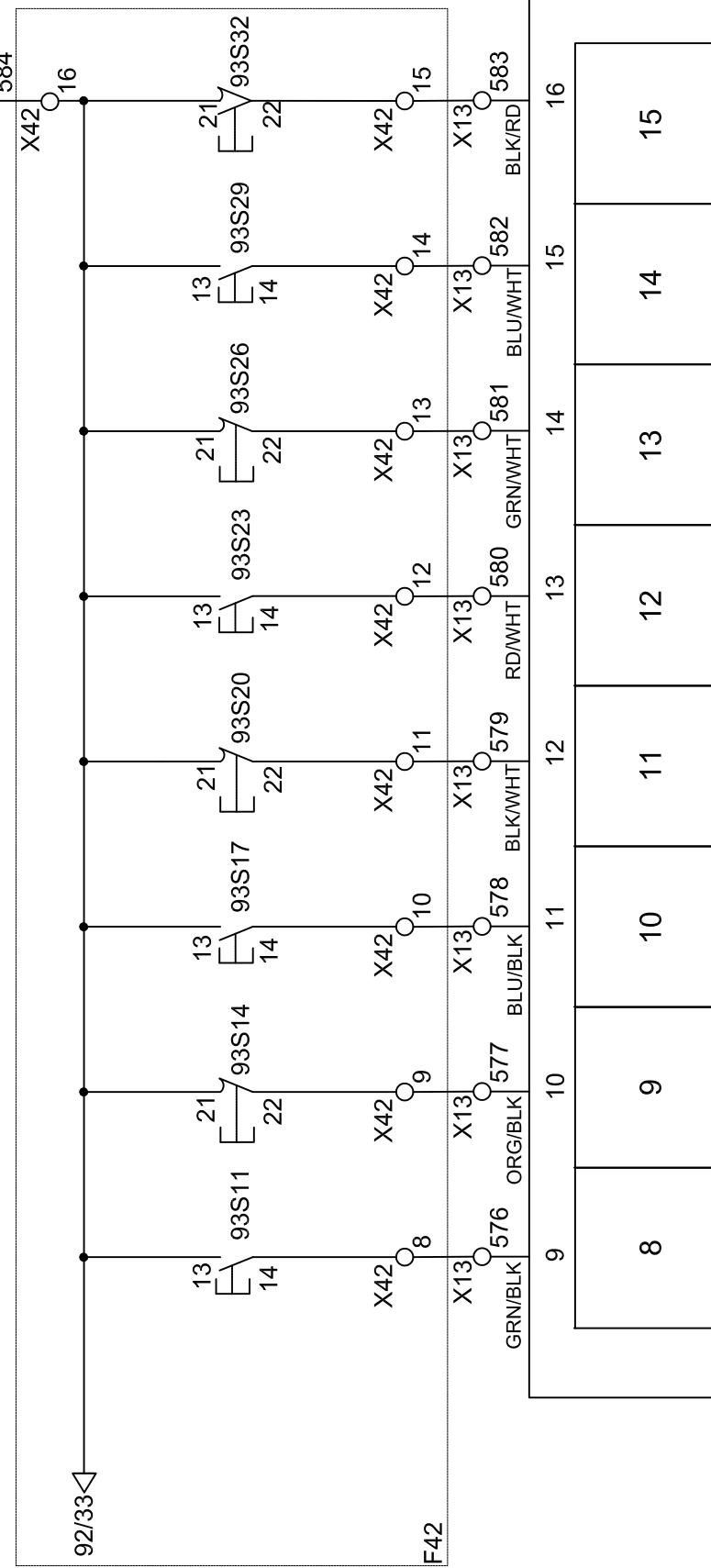
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PRESS ROLL		PRESS ROLL		NIP ROLL 1-ENG		NIP ROLL 1-RETR		NIP ROLL 2-ENG		NIP ROLL 2-RETR		NIP ROLL 3-ENG		NIP ROLL 3-RETR																				
OUTLET-ENG		OUTLET-RETR																																

92/34

94/02



RACK 1 / SLOT 5

Allen Bradley 1756-IB32

I87_8	I87_9	I87_A	I87_B	I87_C	I87_D	I87_E	I87_F
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32 P.L.C. DIGITAL INPUT

INTEPLAST GROUP, Ltd. AMTOPP DIVI. MIE DEPT.				
DRAWN BY	JEFF LEE			
CHECKED BY	VINCENT HUANG			

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN NO.	DRAWN DATE:	KF F13	DRAWING NO.	DRAWING DATE:	Page #
			03-03-2014						93

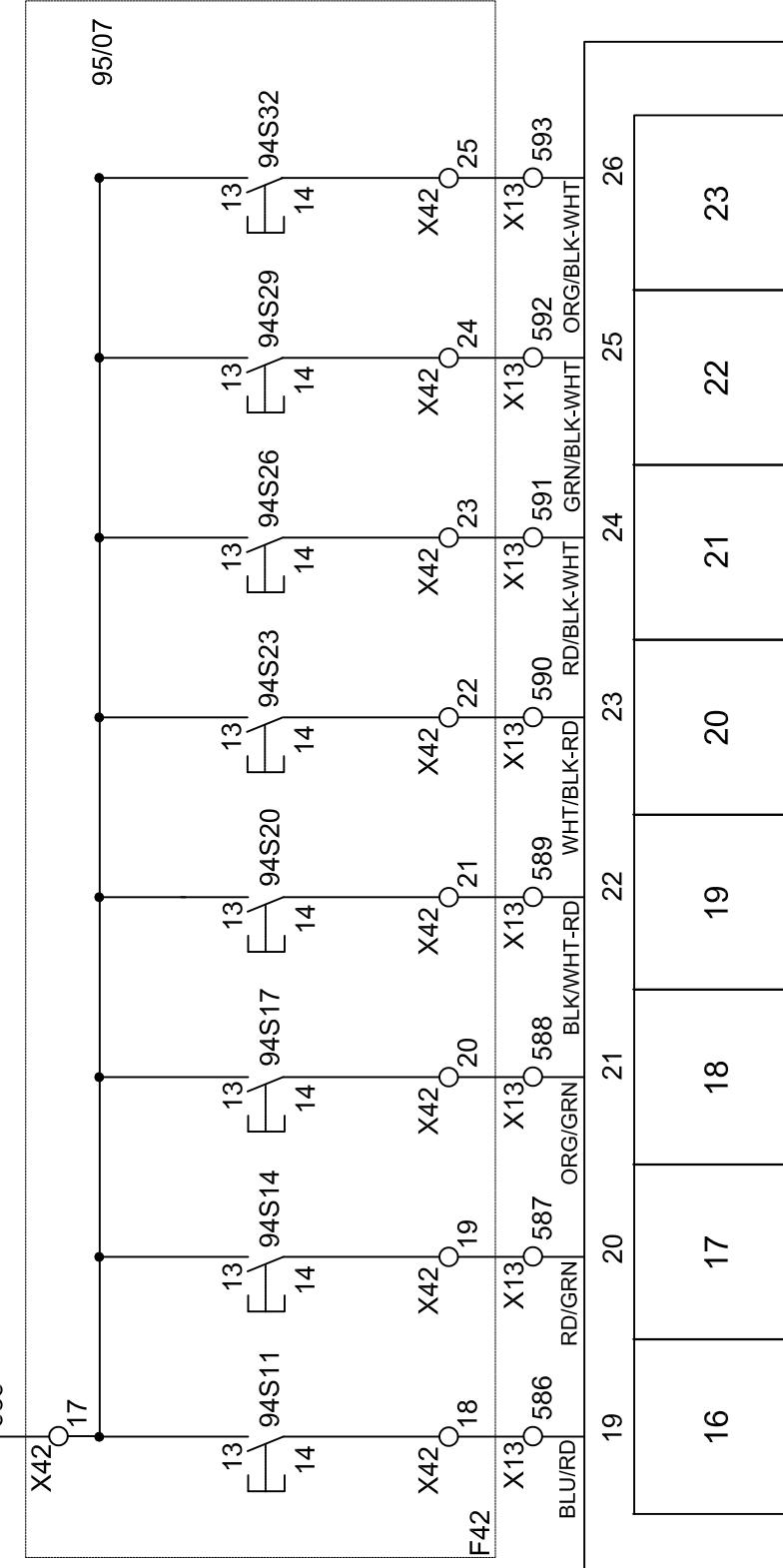
MATERIAL	SCALES	NONES	UNIT	MM
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DRAW ROLL 1-UP	DRAW ROLL 1-DOWN	DRAW ROLL 2-UP	DRAW ROLL 2-DOWN	DRAW ROLL 3-UP	DRAW ROLL 3-DOWN																												

STRETCHING
FAST ROLL

93/34 95/04

X13
585



RACK 1 / SLOT 5

Allen Bradley 1756-IB32

197_0 197_1 197_2 197_3 197_4 197_5 197_6 197_7

INTEPLAST GROUP, Ltd. AMTOPP DIVI. MIE DEPT.							
DRAWN BY	JEFF LEE						
CHECKED BY	VINCENT HUANG						
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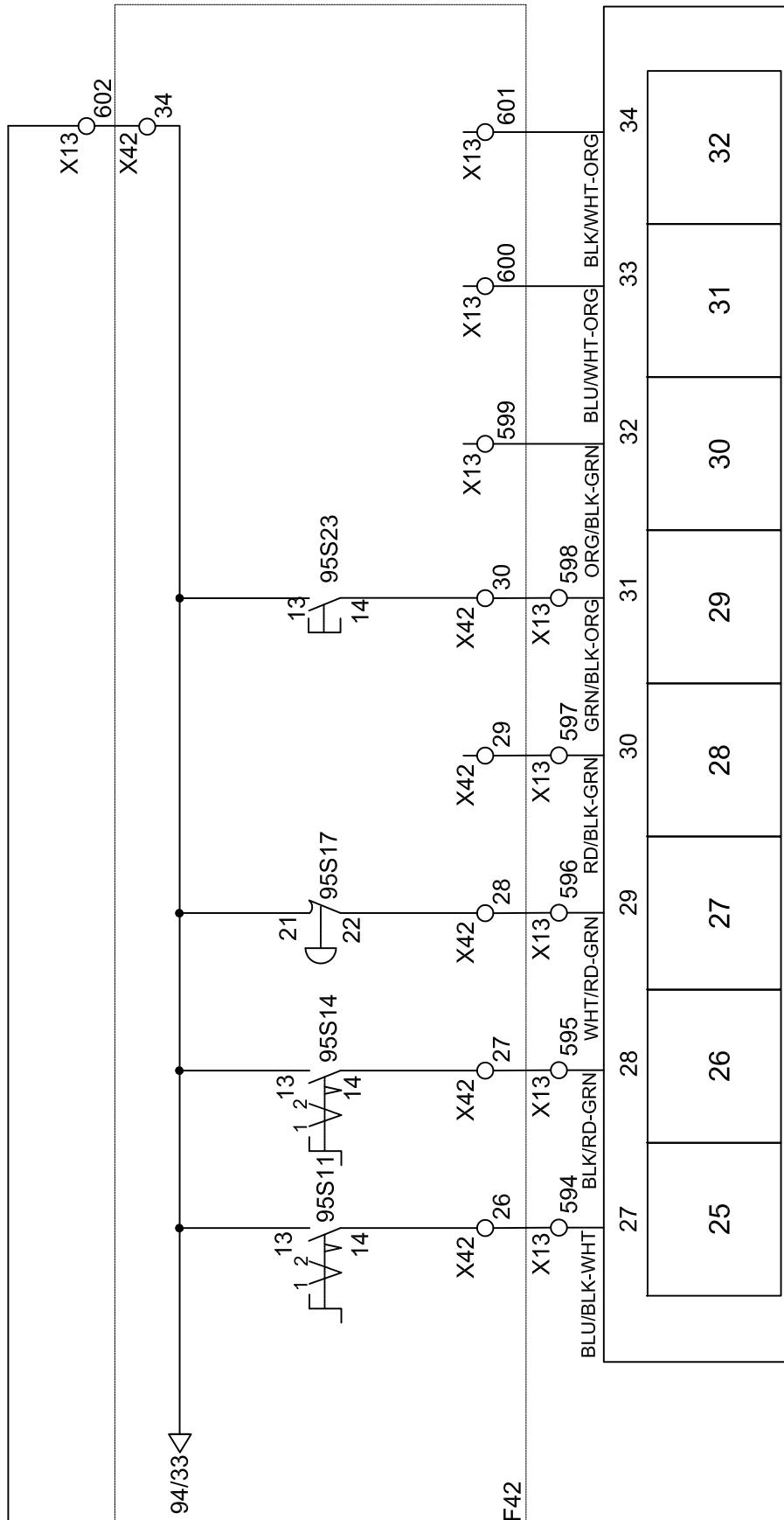
32 P.L.C. DIGITAL INPUT

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03-03-2014

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94/34



RACK 1 / SLOT 5
Allen Bradley 1756-IB

197_F
197_E
197_D
197_C
197_B
197_A
197_9
197_8

32 | C DIGITAL INPUT

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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

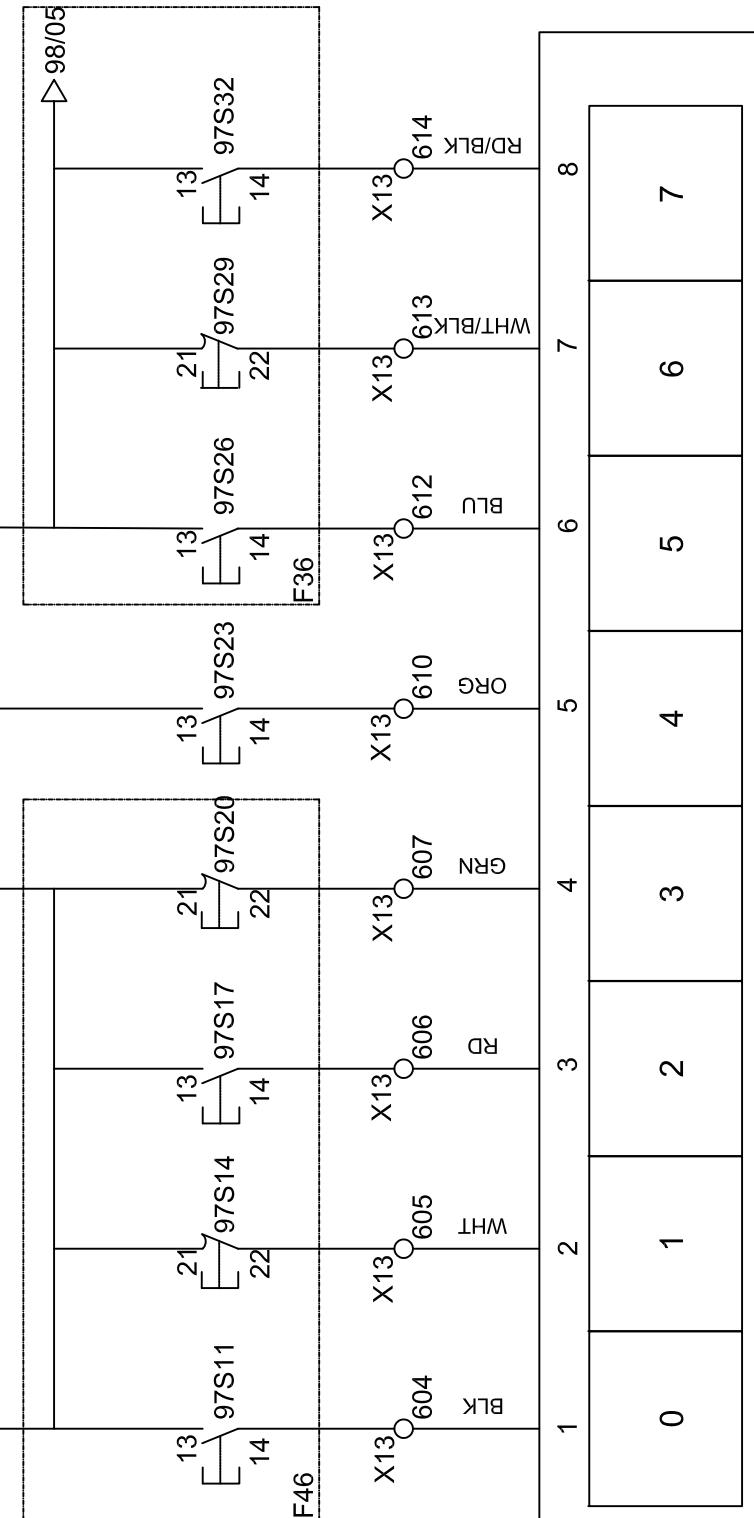
32 B | C DIGITAL INPUT

MOTOR-START 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34
 SPINDLE-ENG. AUX. WINDER 2 AUX. WINDER 1
 MOTOR-STOP 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34
 SPINDLE-RET. FOOT SWITCH MOTOR-START MOTOR-STOP SPINDLE-ENG.

24 VDC / 12Q18
12/18

98/02

98/02

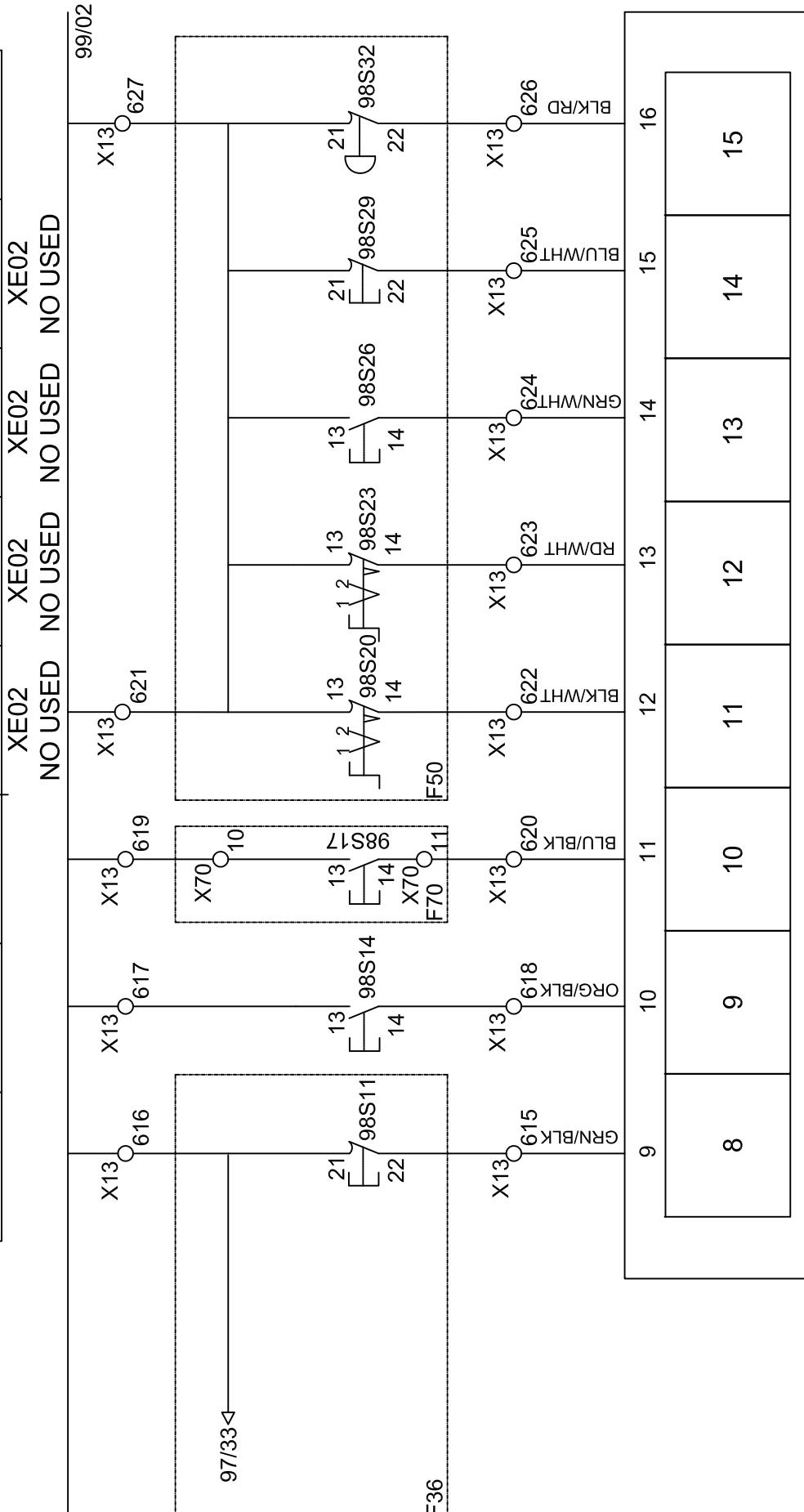


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18 GND-0

18 GND-0

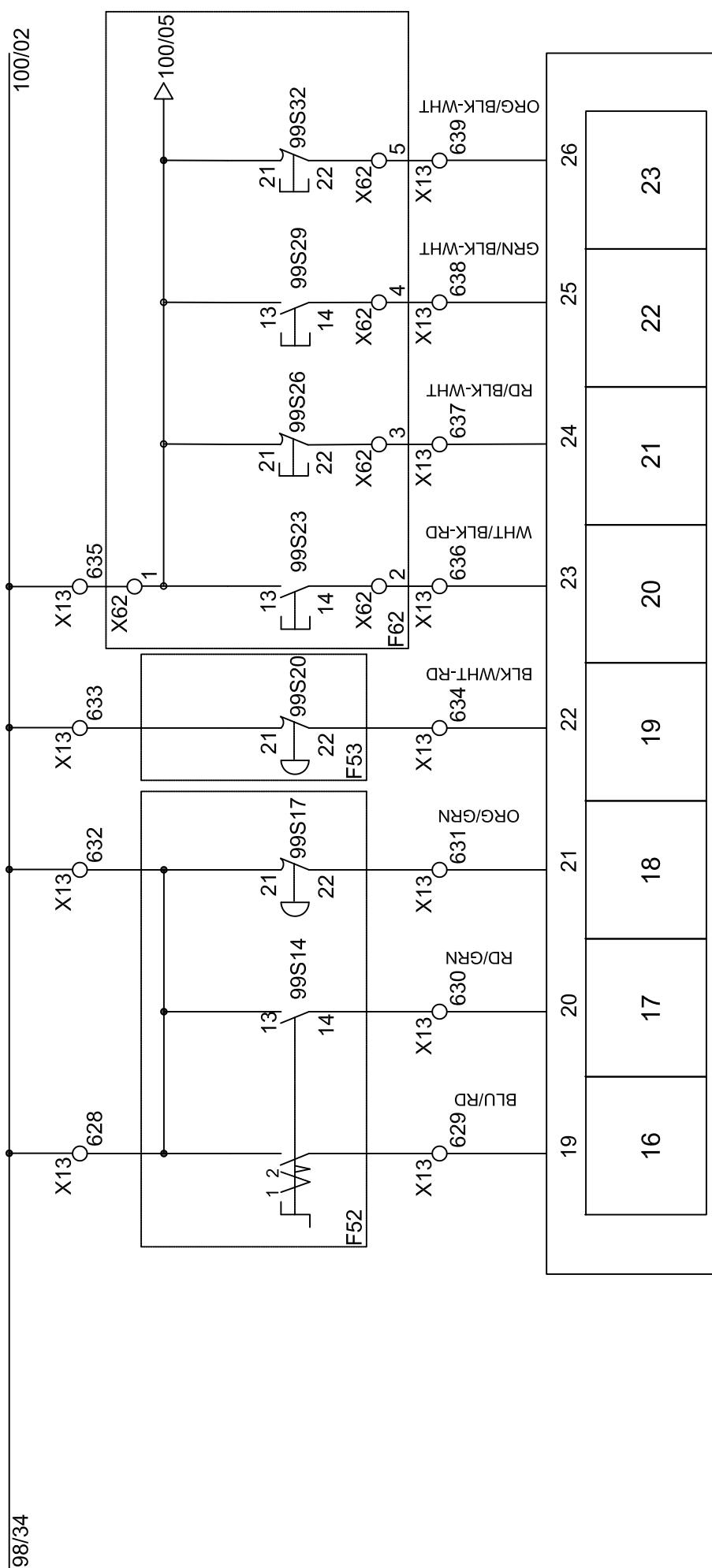
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Allen Bradley 1756-IB32

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RACK 1 / SLOT 6
Allen Bradley 1756-IB

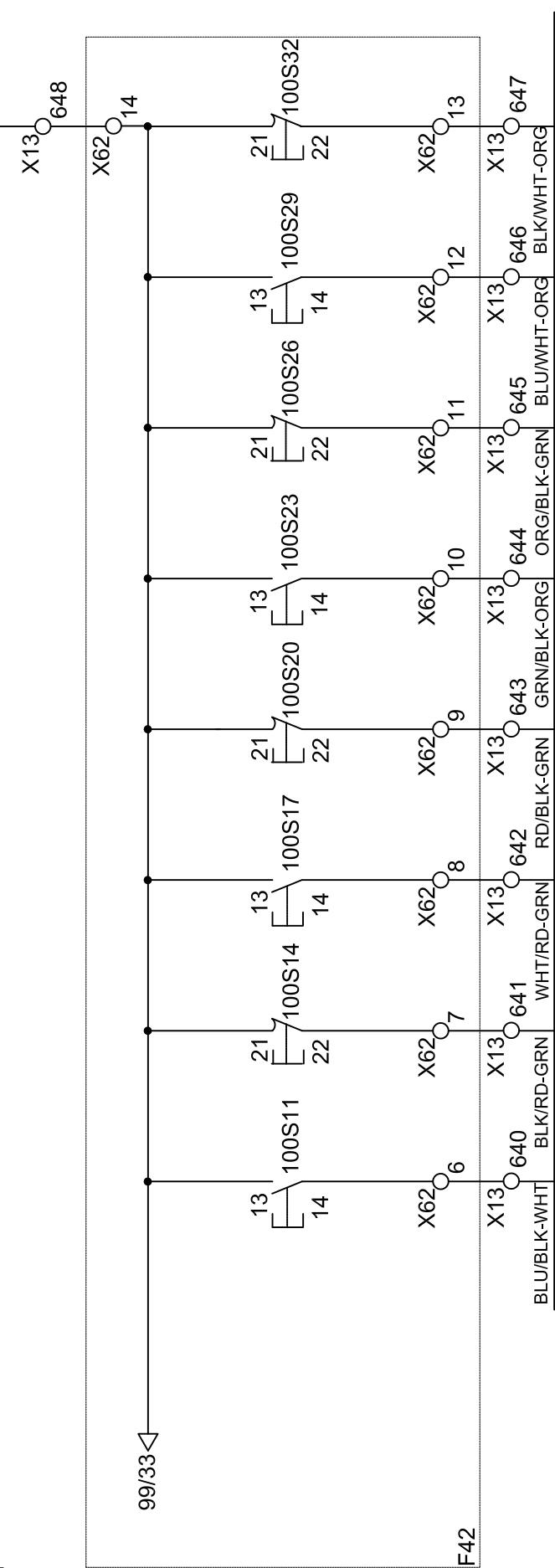
32 P.L.C. DIGITAL INPUT



RACK 1 / SLOT 6
Allen Bradley 1756-IE

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OP KNIFE-ENGAGE	OP KNIFE-RETRACT	DRIVE KNIFE-ENGAGE	DRIVE KNIFE-RETRACT	OP. SPREADER ROLL ENG.	OP. SPREADER ROLL RETR.	OP. SPREADER ROLL ENG.	OP. SPREADER ROLL RETR.	DRIVE SPREADER ROLL 1 ENG.	DRIVE SPREADER ROLL 1 RETR.																								

99/34



27	28	29	30	31	32	33	34
24	25	26	27	28	29	30	31

RACK 1 / SLOT 6

Allen Bradley 1756-IB32

IB0_8	IB0_9	IB0_A	IB0_B	IB0_C	IB0_D	IB0_E	IB0_F
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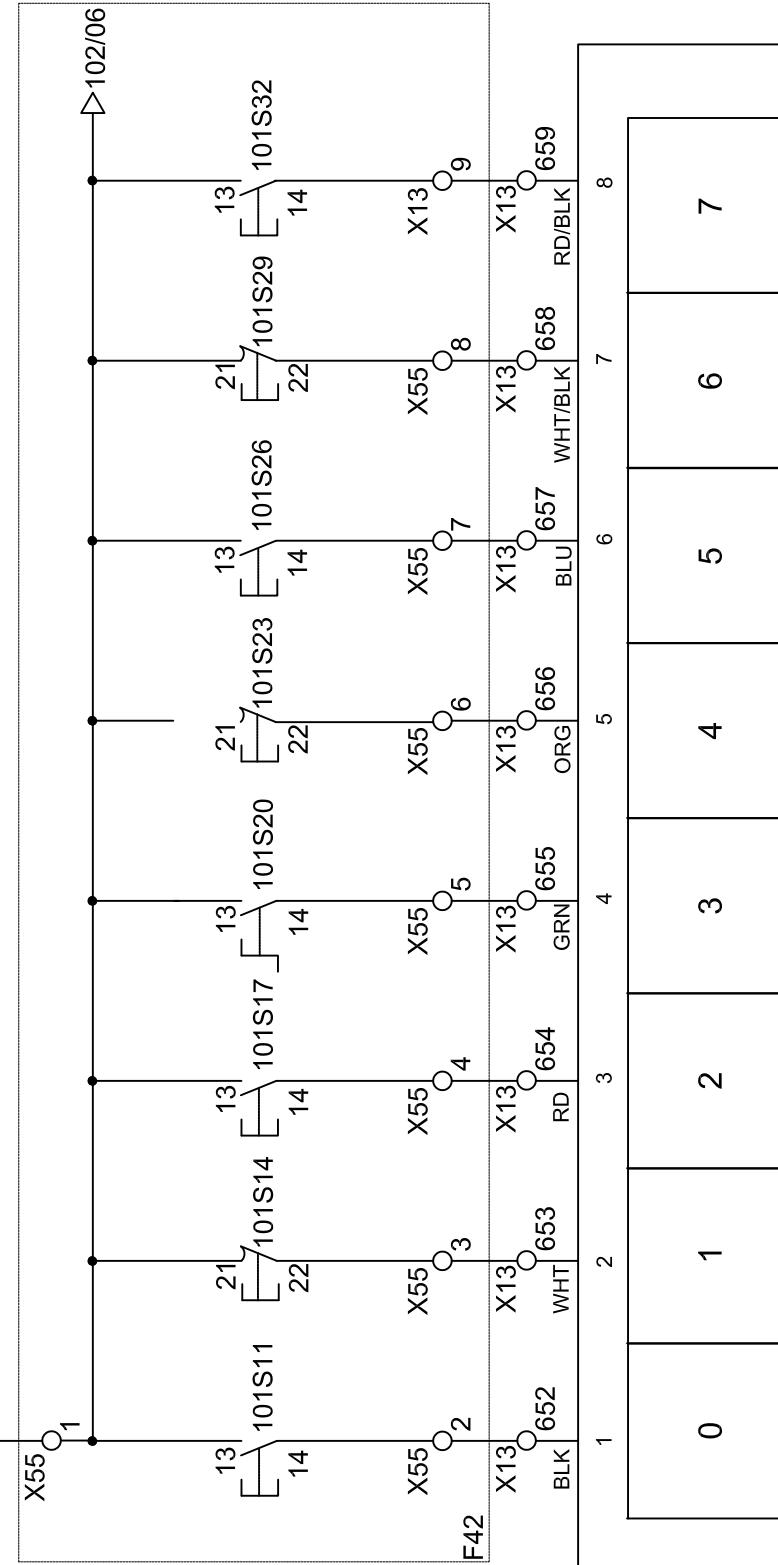
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VACUUM ROLL 1-START	VACUUM ROLL 1-STOP	WEB BREAK PRS BY-PASSION	OZONE EXHAUST FAN.1 START	OZONE EXHAUST FAN.1 STOP	OZONE EXHAUST FAN.2 START	OZONE EXHAUST FAN.2 STOP	OZONE EXHAUST FAN.3 START	OZONE EXHAUST FAN.3 STOP																									

24 VDC / 12Q20
12/20

X13
651



102/02

0 VDC
12/20 ORG/WHT-BLU
ORG/RD
18 GND-0
36 GND-1

RACK 1 / SLOT 7
Allen Bradley 1756-IB32

IA1_0 IA1_1 IA1_2 IA1_3 IA1_4 IA1_5 IA1_6 IA1_7

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12/20 ORG/WHT-BLU
ORG/RD
18 GND-0
36 GND-1

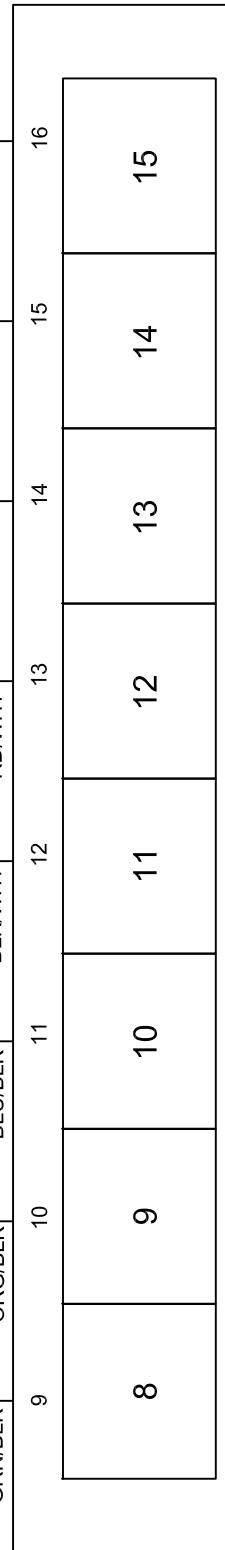
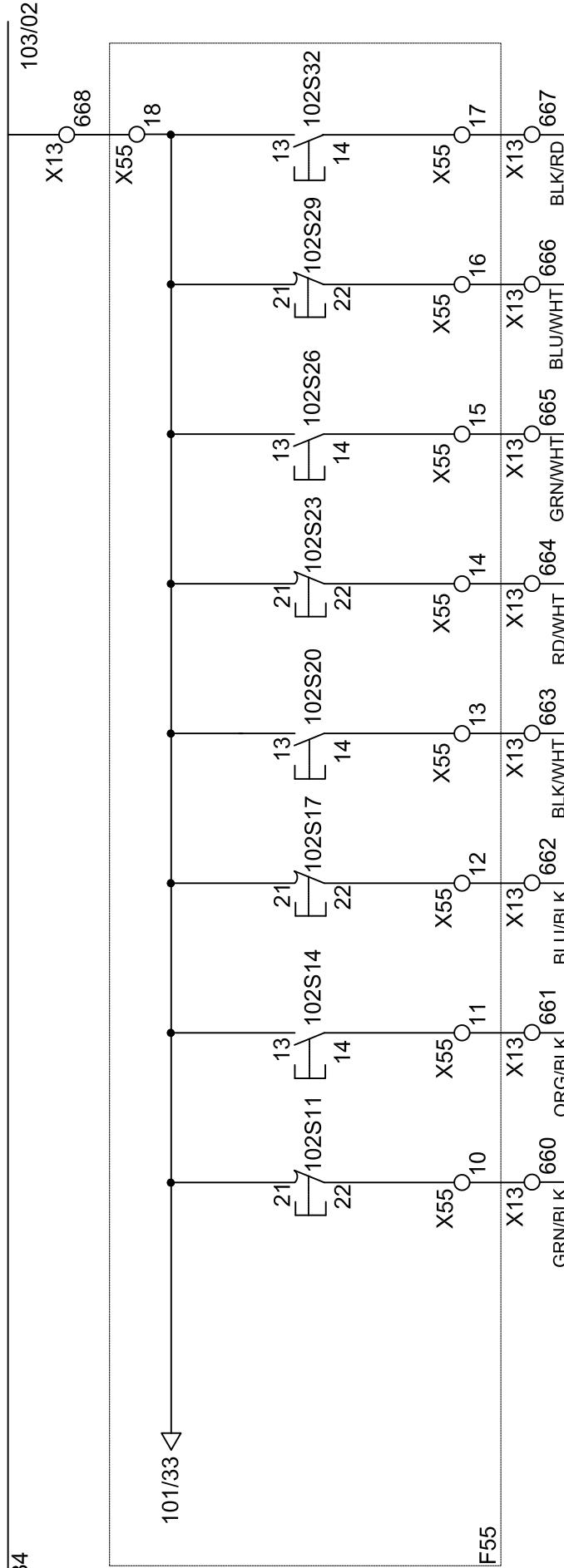
102/02

32 P.L.C. DIGITAL INPUT

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						MM		

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OZONE EXHAUST FAN STOP	ROLL 2 START	VACCUM ROLL 2 STOP	NIP ROLL FOR CORONA#1 ENG.	NIP ROLL FOR CORONA#1 RETR.	NIP ROLL FOR CORONA#1 ENG.	COR. ELECTRODE 1 ENG. A&B	COR. ELECTRODE 1 RETR. A&B	NIP ROLL FOR CORONA#2 ENG.	NIP ROLL FOR CORONA#2 ENG.																								

101/34



RACK 1 / SLOT 7
Allen Bradley 1756-IB32

IA1_8 IA1_9 IA1_A IA1_B IA1_C IA1_D IA1_E IA1_F

32 P.L.C. DIGITAL INPUT

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By	Byan Hong
Date	11/28/2023

INTEPLAST GROUP, Ltd.	AMTOPP DIVI. MIE DEPT.
DRAWN BY	JEFF LEE
CHECKED BY	VINCENT HUANG

Page #	102
Total	

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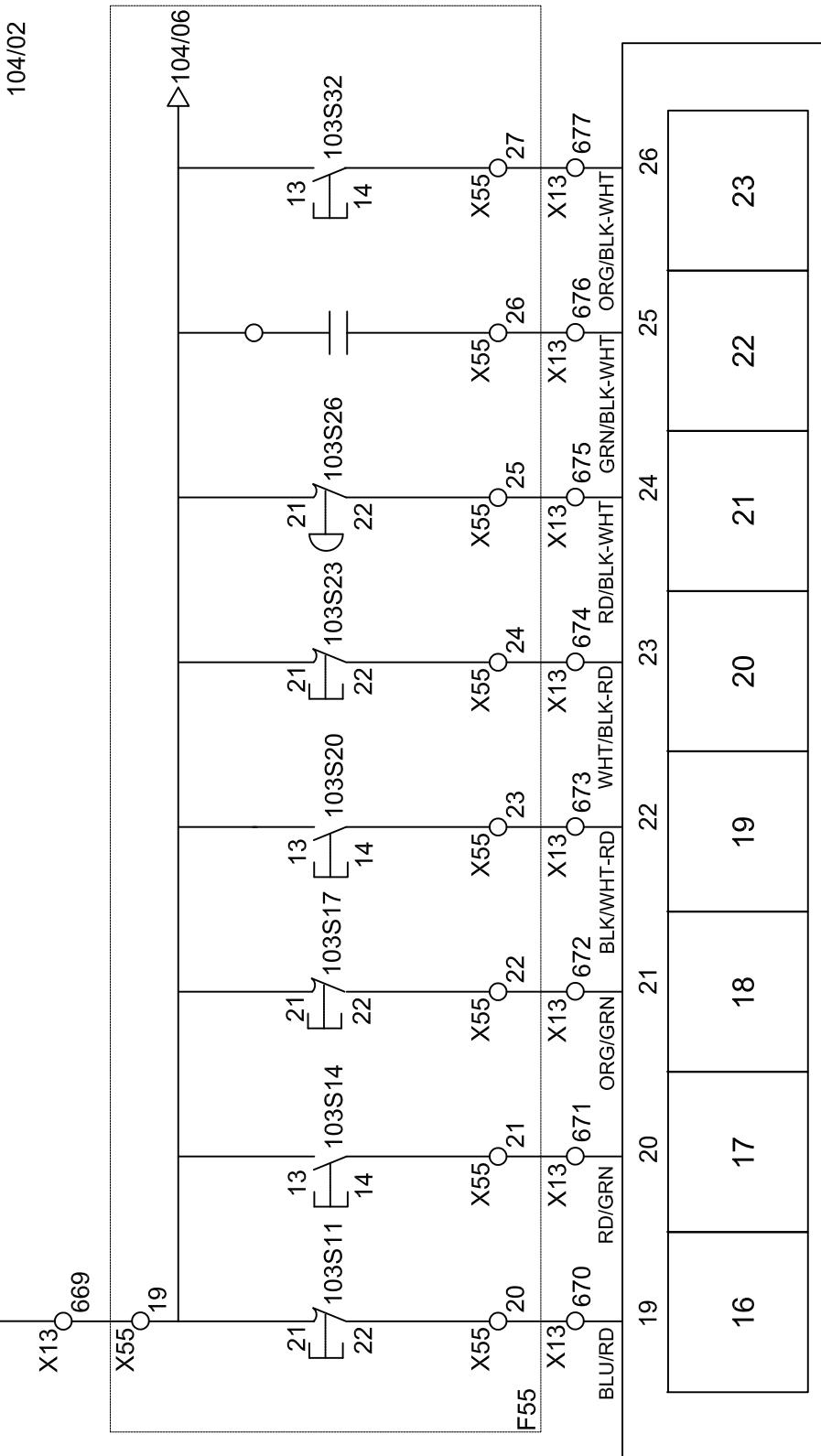
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By	Byan Hong
Date	11/28/2023

INTEPLAST GROUP, Ltd.	AMTOPP DIVI. MIE DEPT.
DRAWN BY	JEFF LEE
CHECKED BY	VINCENT HUANG

104/02



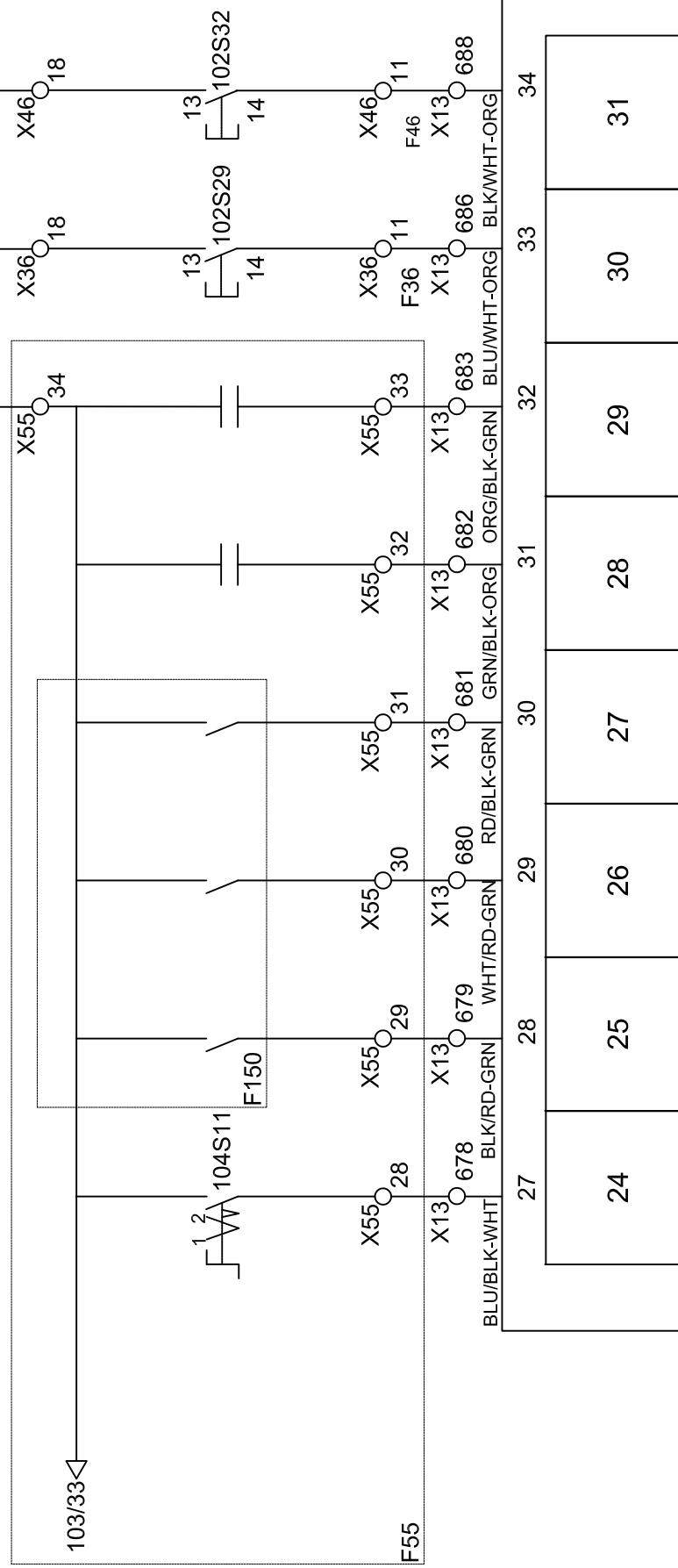
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Allen Bradley 1756-IB

IB1_0 IB1_1 IB1_2 IB1_3 IB1_4 IB1_5 IB1_6 IB1_7

32 | C DIGITAL INPUT

Page #	103		
	Total		
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		KF F13	
			MATERIAL

103/34

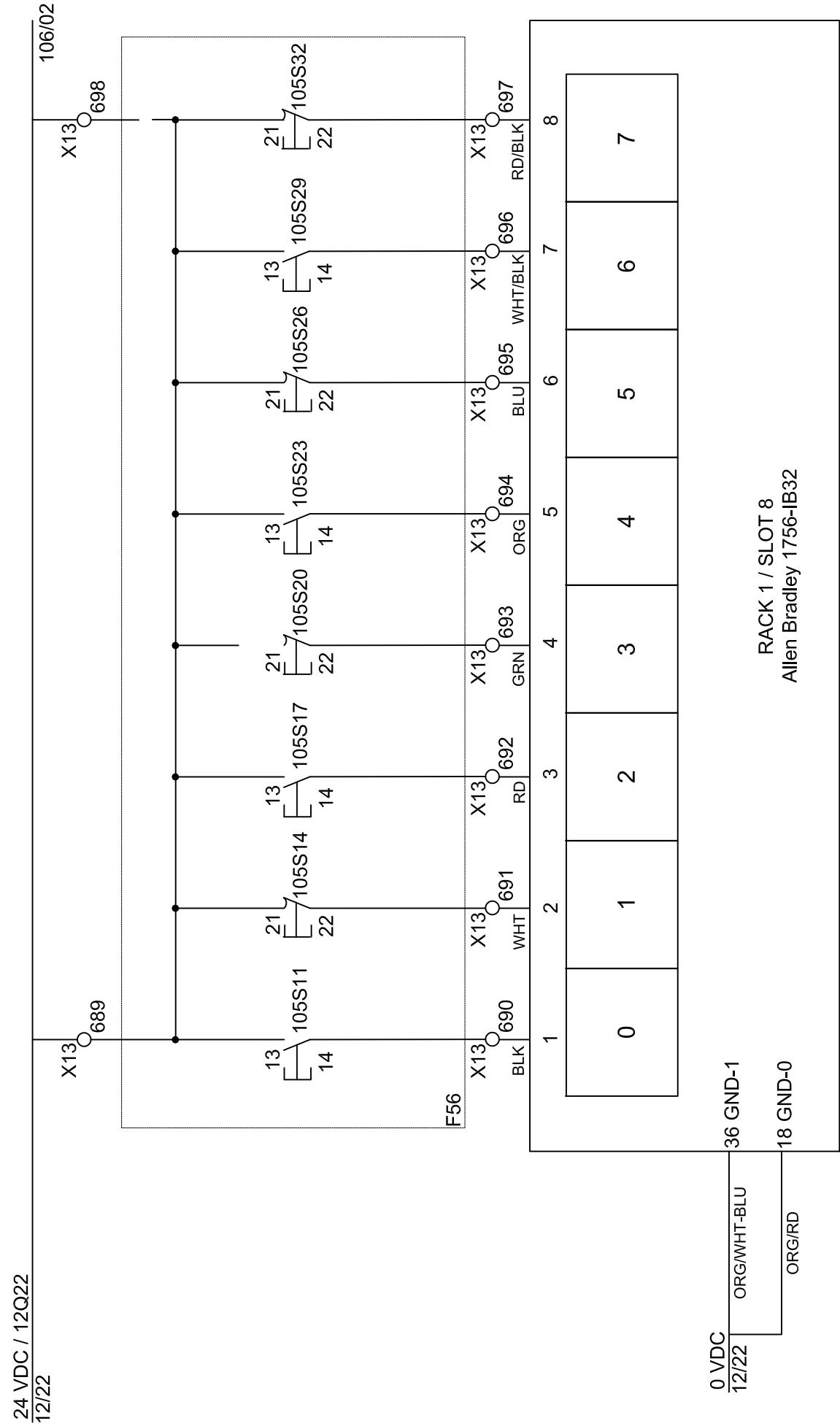


RACK 1 / SLOT 7
Allen Bradley 1756-IB

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33	34						
							104

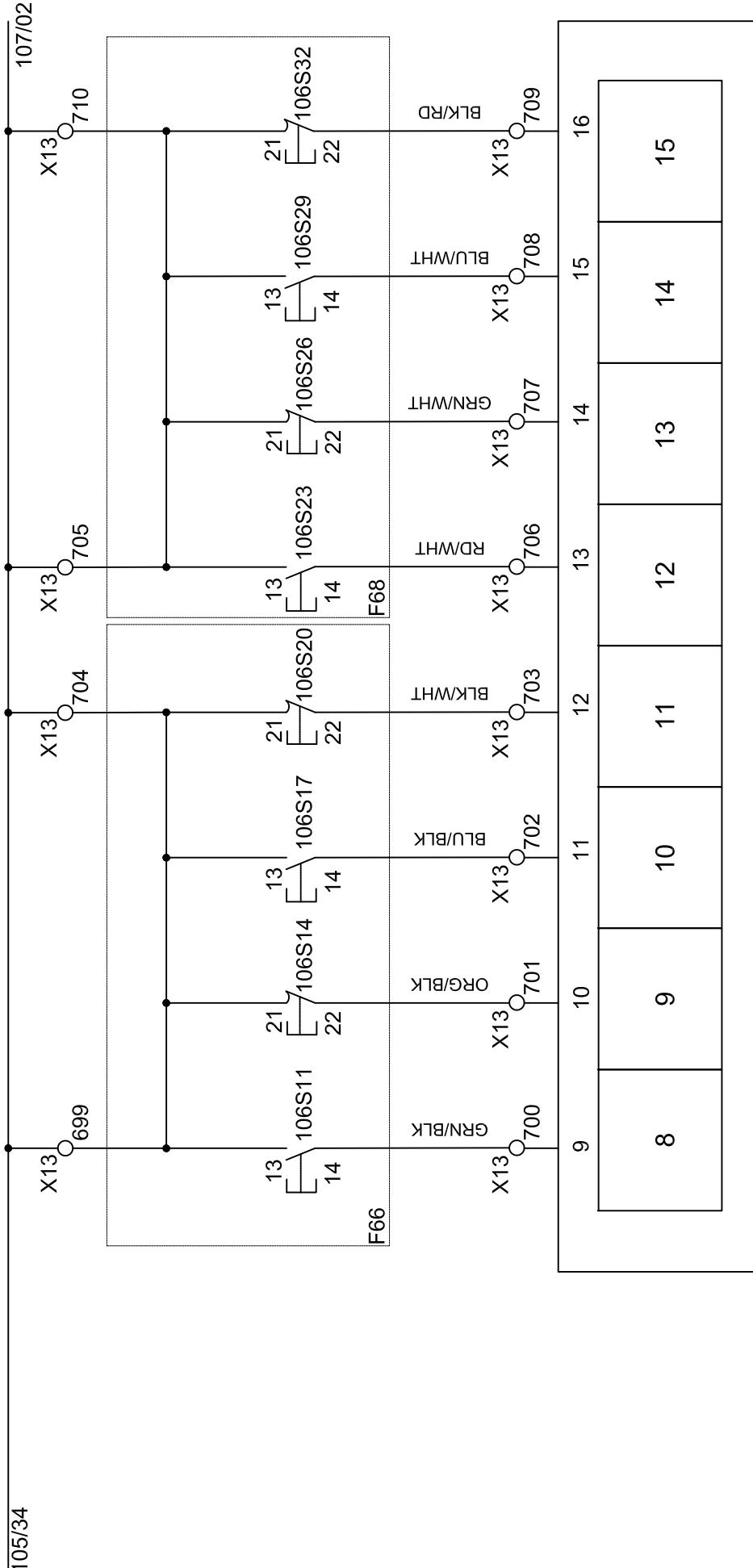
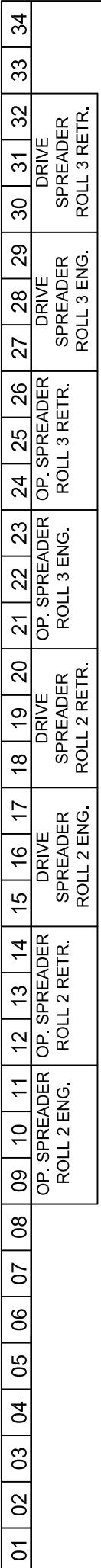
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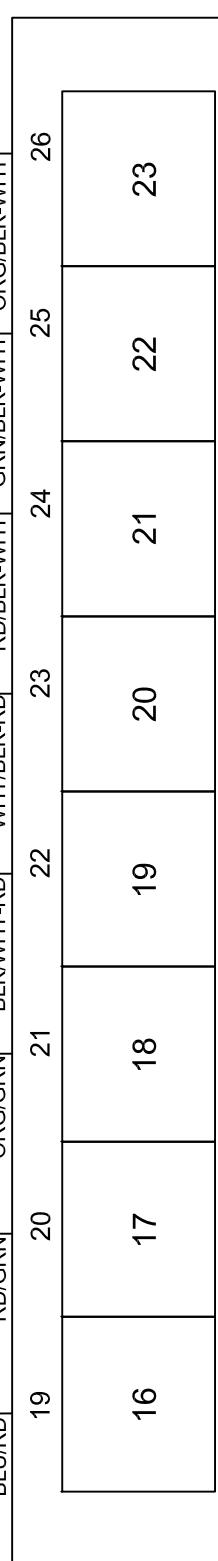
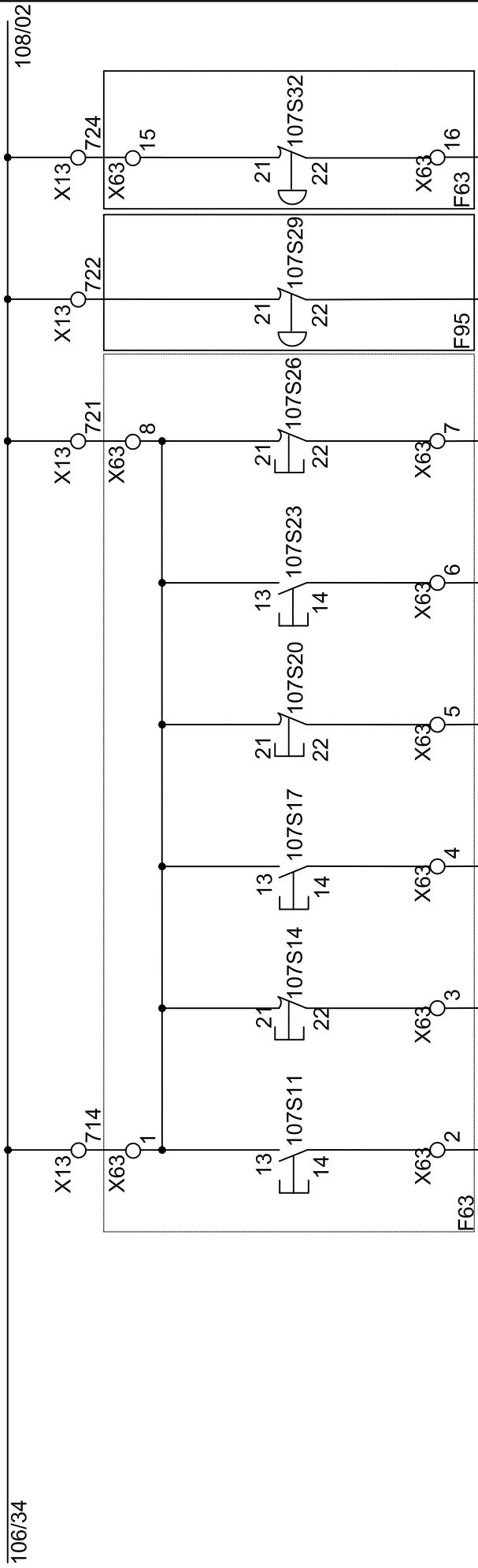
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32-BIT DIGITAL INPUT



RACK 1 / SLOT 8
Allen Bradley 1756-IB32

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NIP ROLL ENG.	NIP ROLL RETR.	KNIFE ENGAGE	KNIFE RETRACT	SPREAD	ROLL 1 ENG.	ROLL 1 RETR.	PRS STOP	PRS STOP																									



RACK 1 / SLOT 8

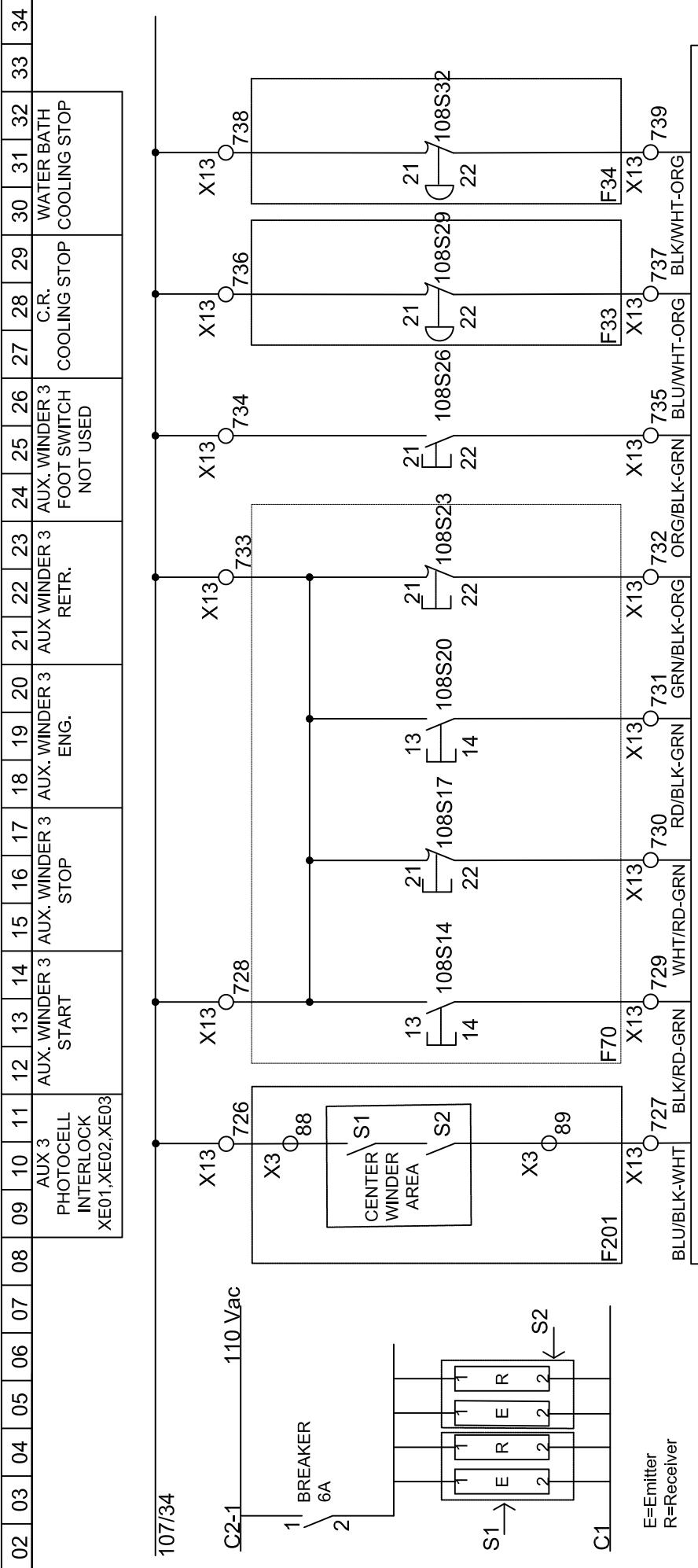
Allen Bradley 1756-IB32

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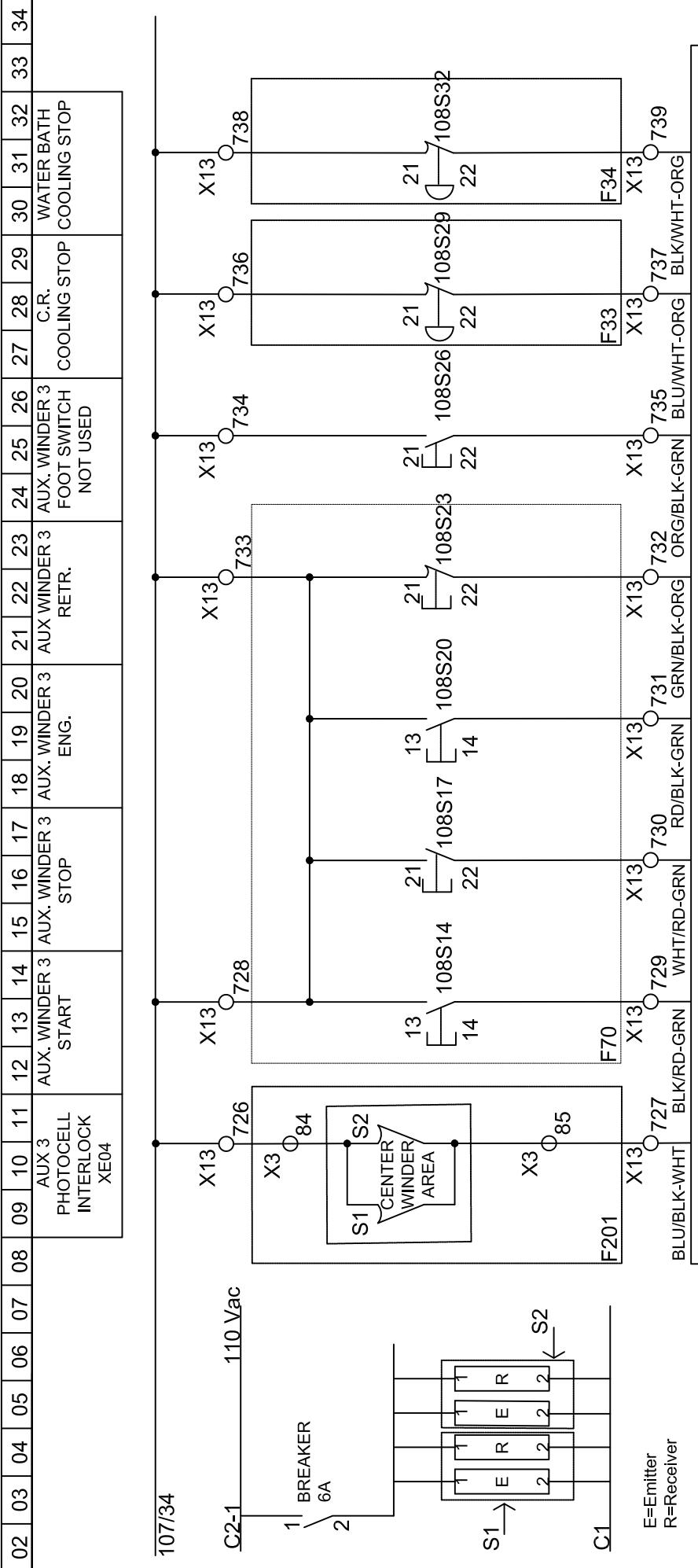
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CHECKED BY	VINCENT HUANG																																
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32 P.L.C. DIGITAL INPUT





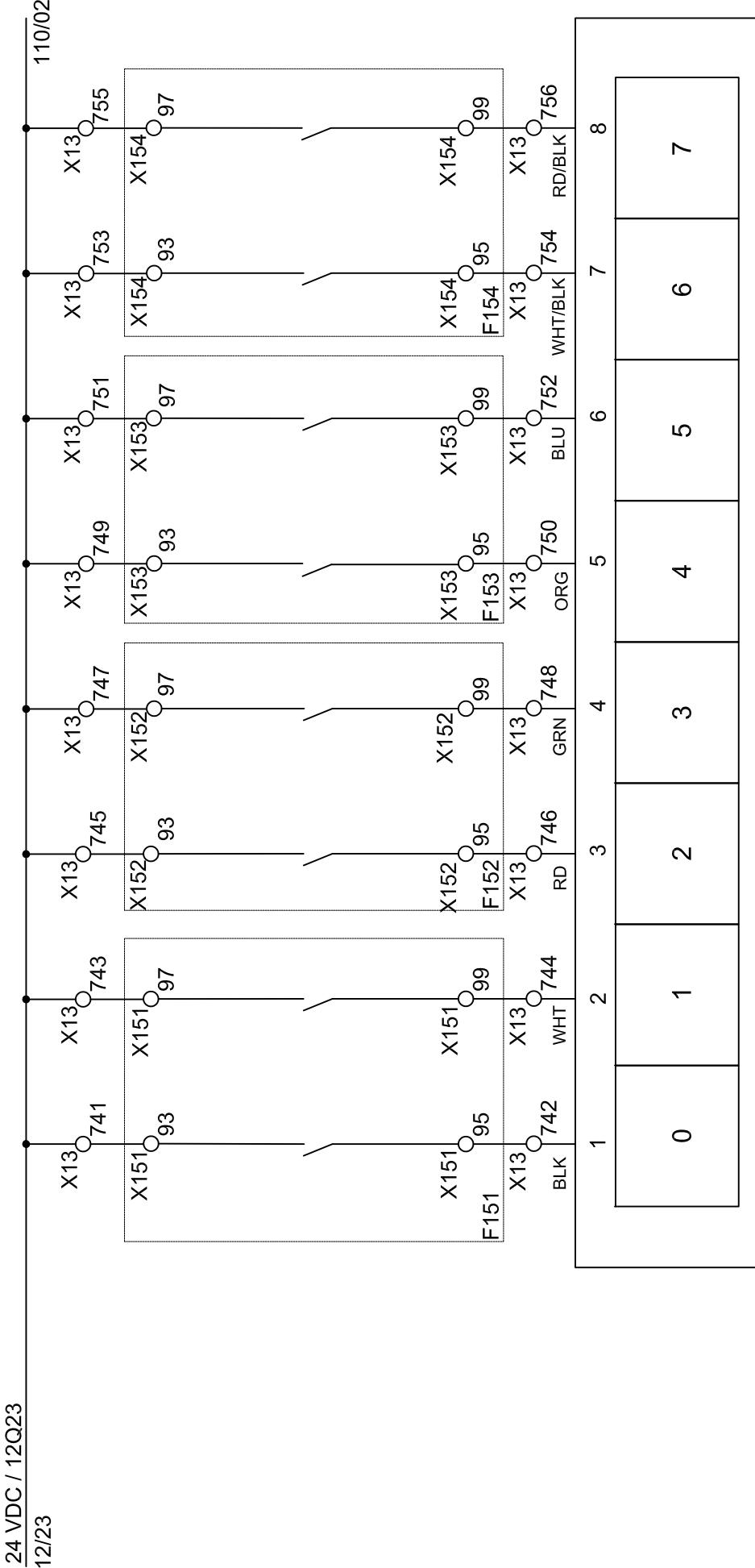
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Allen Bradley 1756-IE



RACK 1 / SLOT 8
Allen Bradley 1756-IB

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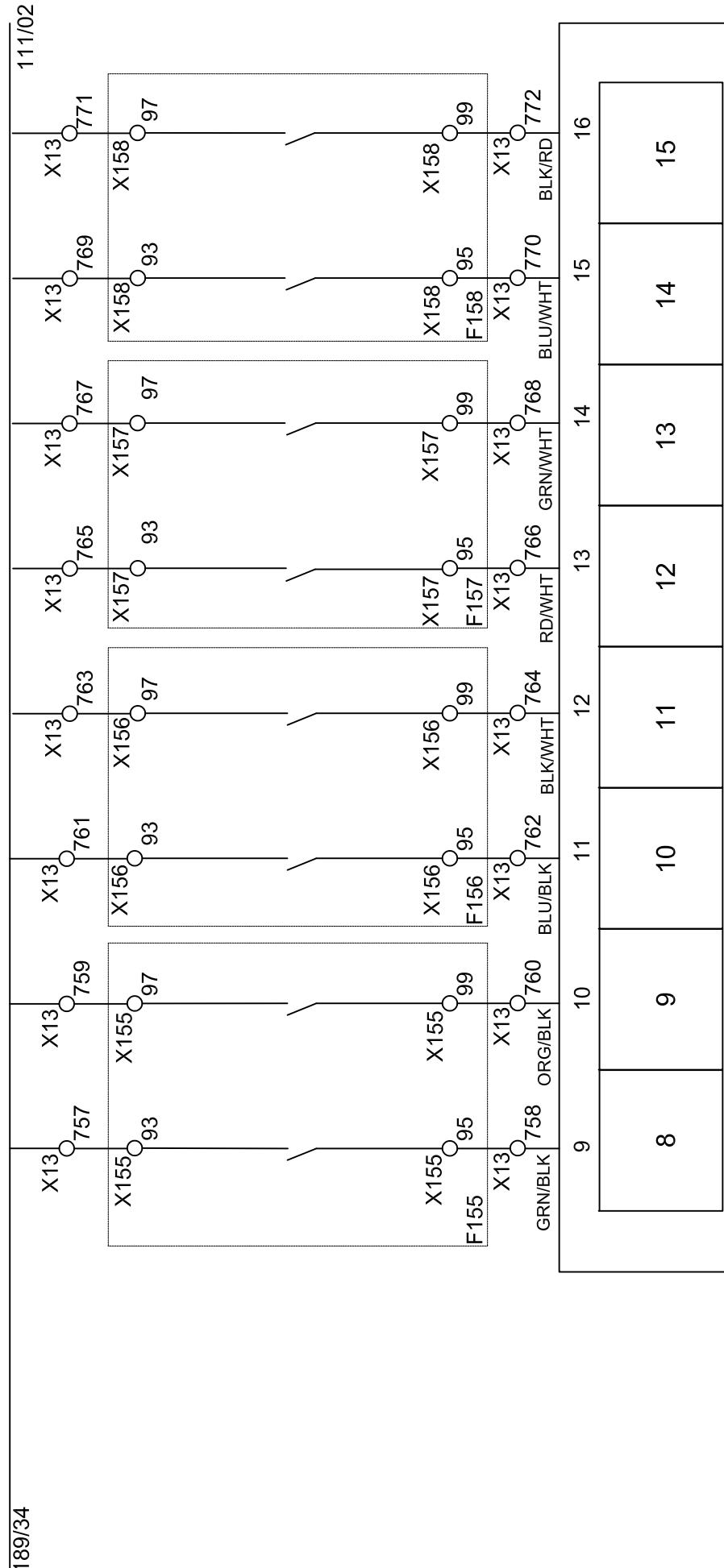


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18 GND-0

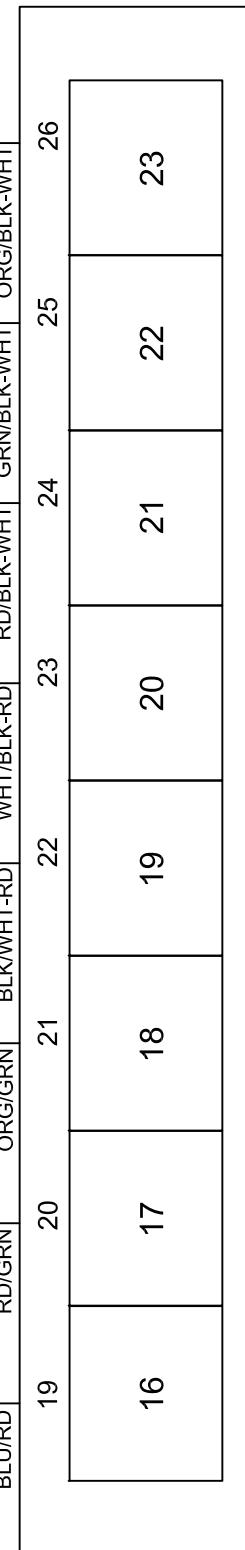
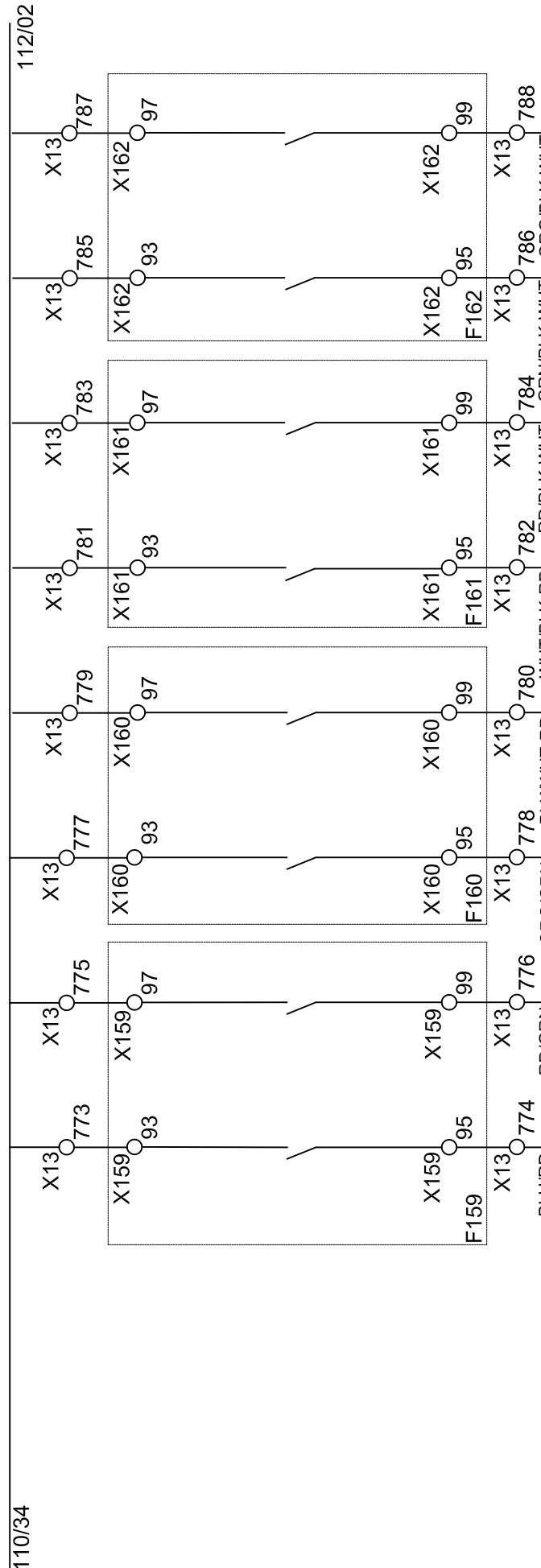
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32 P.L.C. DIGITAL INPUT

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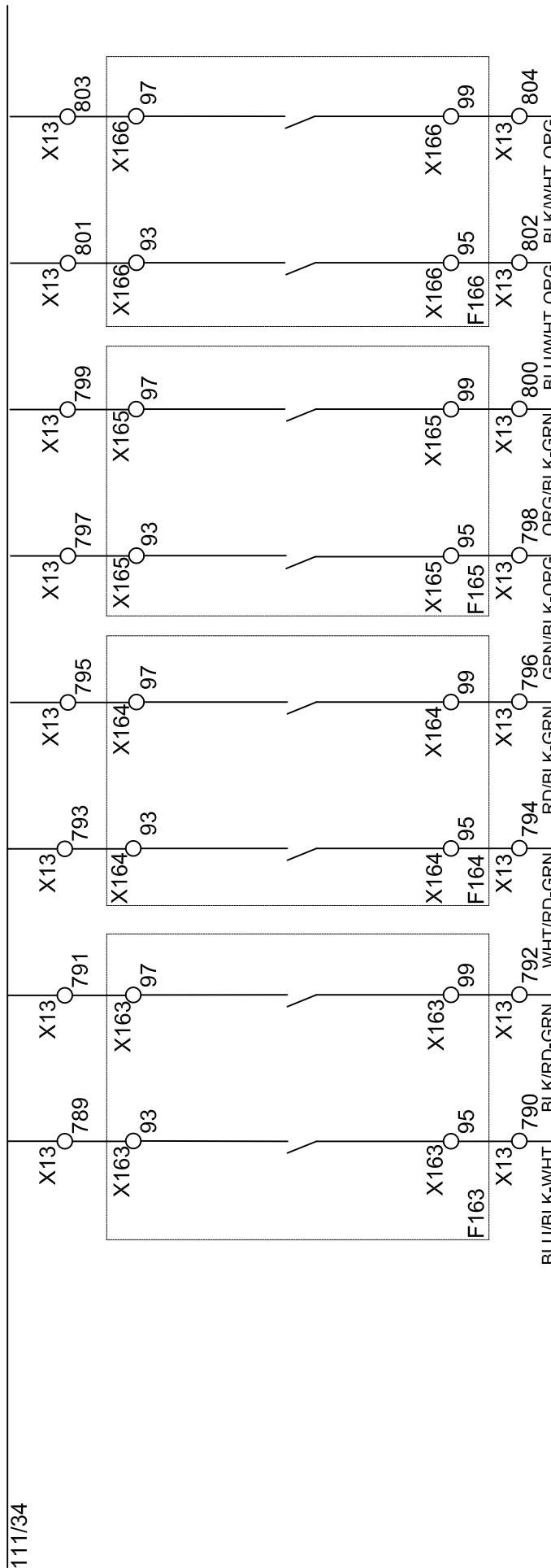
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Allen Bradley 1756-IB



RACK 1 / SLOT 9
Allen Bradley 1756-IB

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BURNER 13 ON	BURNER 13 DEFECT	BURNER 13 ON	BURNER 14 ON	BURNER 14 DEFECT	BURNER 15 ON	BURNER 15 DEFECT	BURNER 15 ON	BURNER 15 DEFECT	BURNER 16 ON	BURNER 16 DEFECT	BURNER 16 ON	BURNER 16 DEFECT																					
111/34																																	



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24	25	26	27	28	29	30	31

RACK 1 / SLOT 9
Allen Bradley 1756-IB32

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32 P.L.C. DIGITAL INPUT

Page # 112
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11/30/2023

Eryan Hong

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03-03-2014

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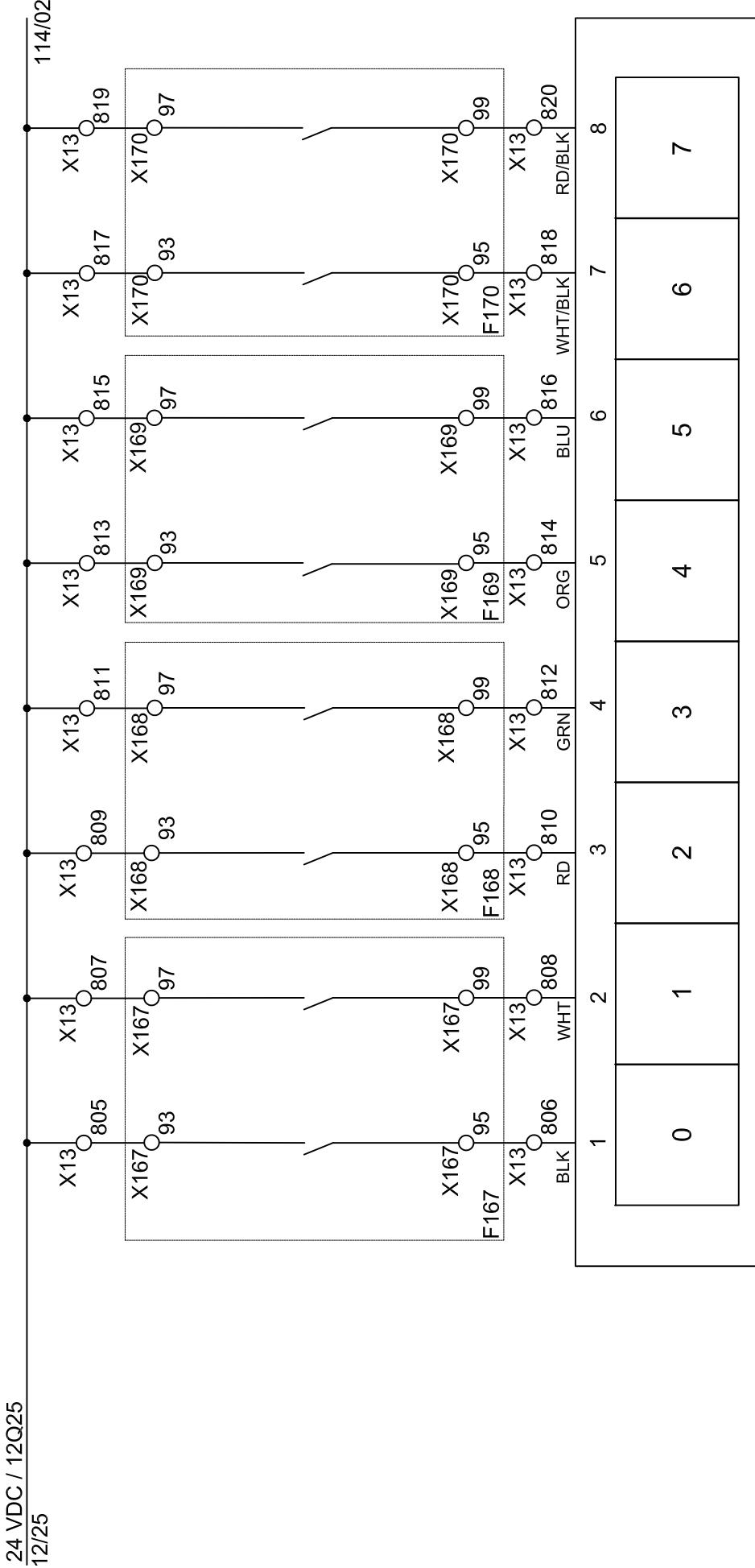
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. MIE DEPT.

JEFF LEE

VINCENT HUANG

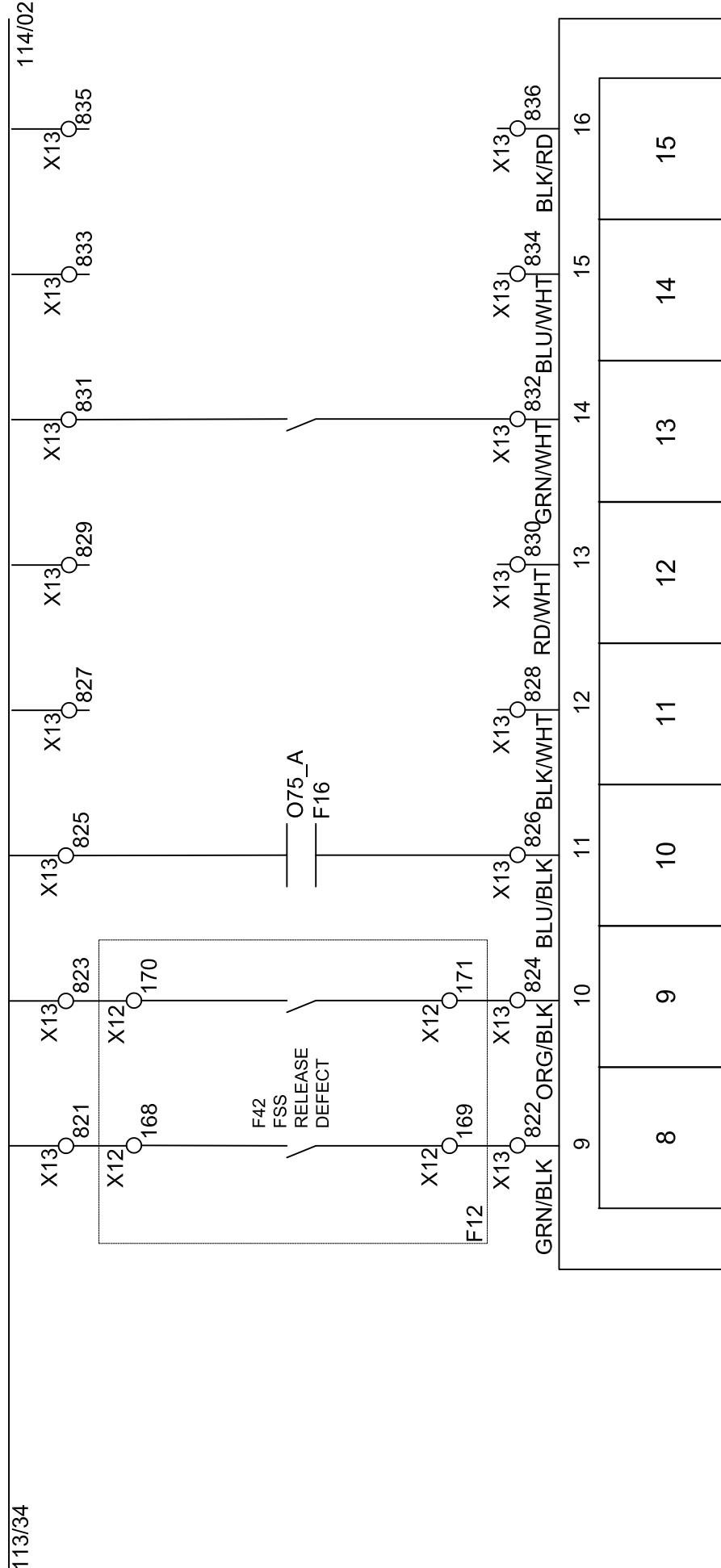


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			18 GND-0

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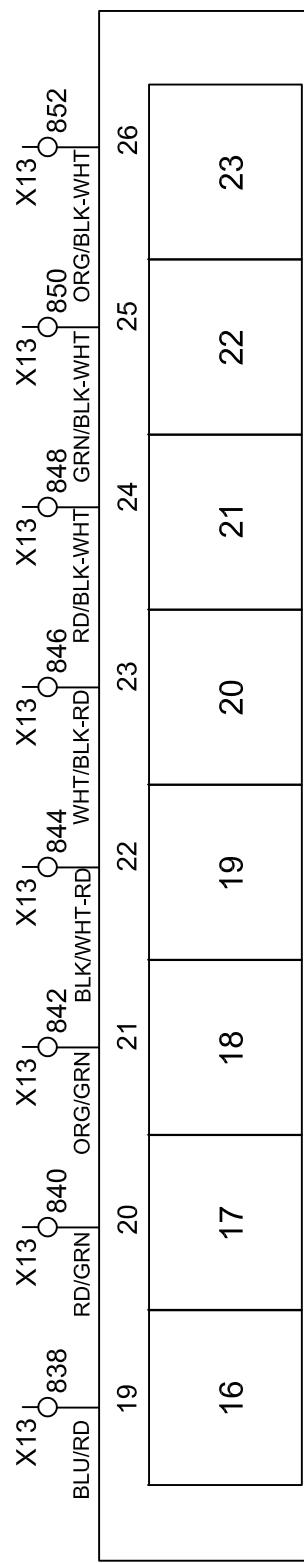
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32 | C DIGITAL INPUT



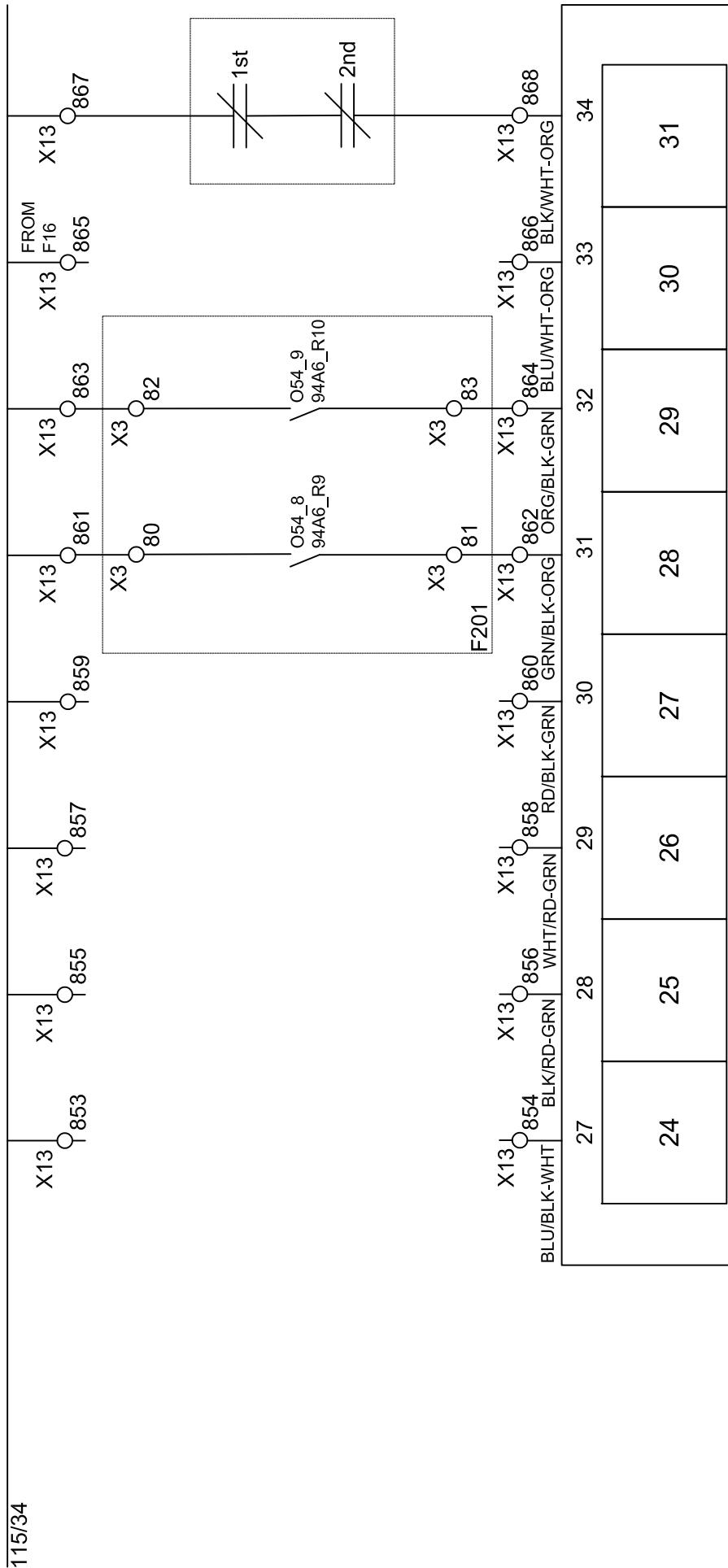
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Allen Bradley 1756-IB32

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RACK 1 / SLOT 10
Allen Bradley 1756-IB3

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FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		FREE		WEB BREAK		WINDER RUNNING		FROM F16		FROM F16		FREE		LIGHT BARRIER PRS			



RACK 1 / SLOT 10
Allen Bradley 1756-IB32

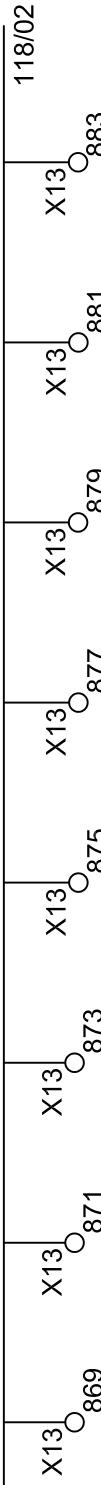
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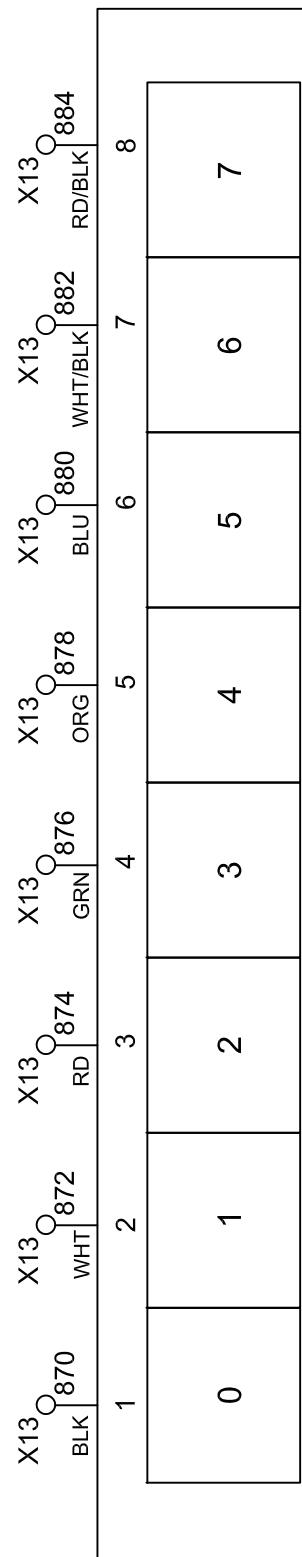
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24 VDC / 12Q27
12/27



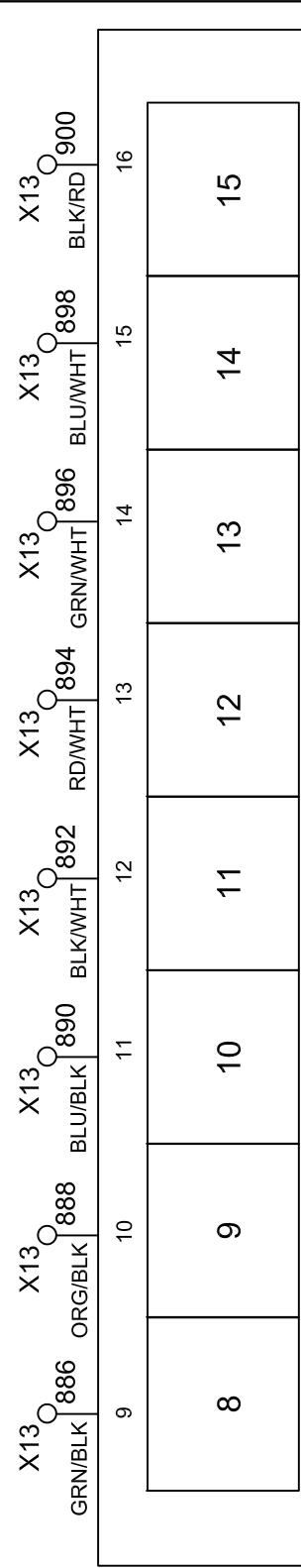
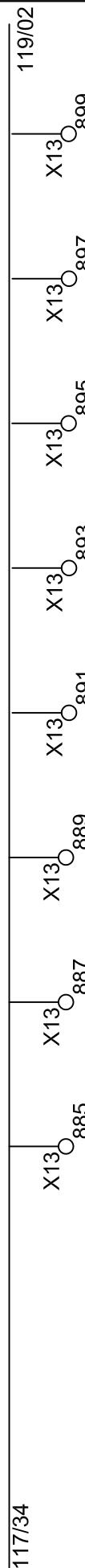
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CHEECKED BY	VINCENT HUANG					Total		MATERIAL																									
						Page #	117																										

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FREE																																	



RACK 1 / SLOT 11
Allen Bradley 1756-IB32

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32 P.L.C. DIGITAL INPUT



Page # 118

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MM

REV. NO

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03-03-2014

Byan Hong

11/30/2023

DRAWING NO.

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Page #

1118/34 | X13○₉₀₁ | X13○₉₀₃ | X13○₉₀₅ | X13○₉₀₇ | X13○₉₀₉ | X13○₉₁₁ | X13○₉₁₃ | X13○₉₁₅ | 120/02

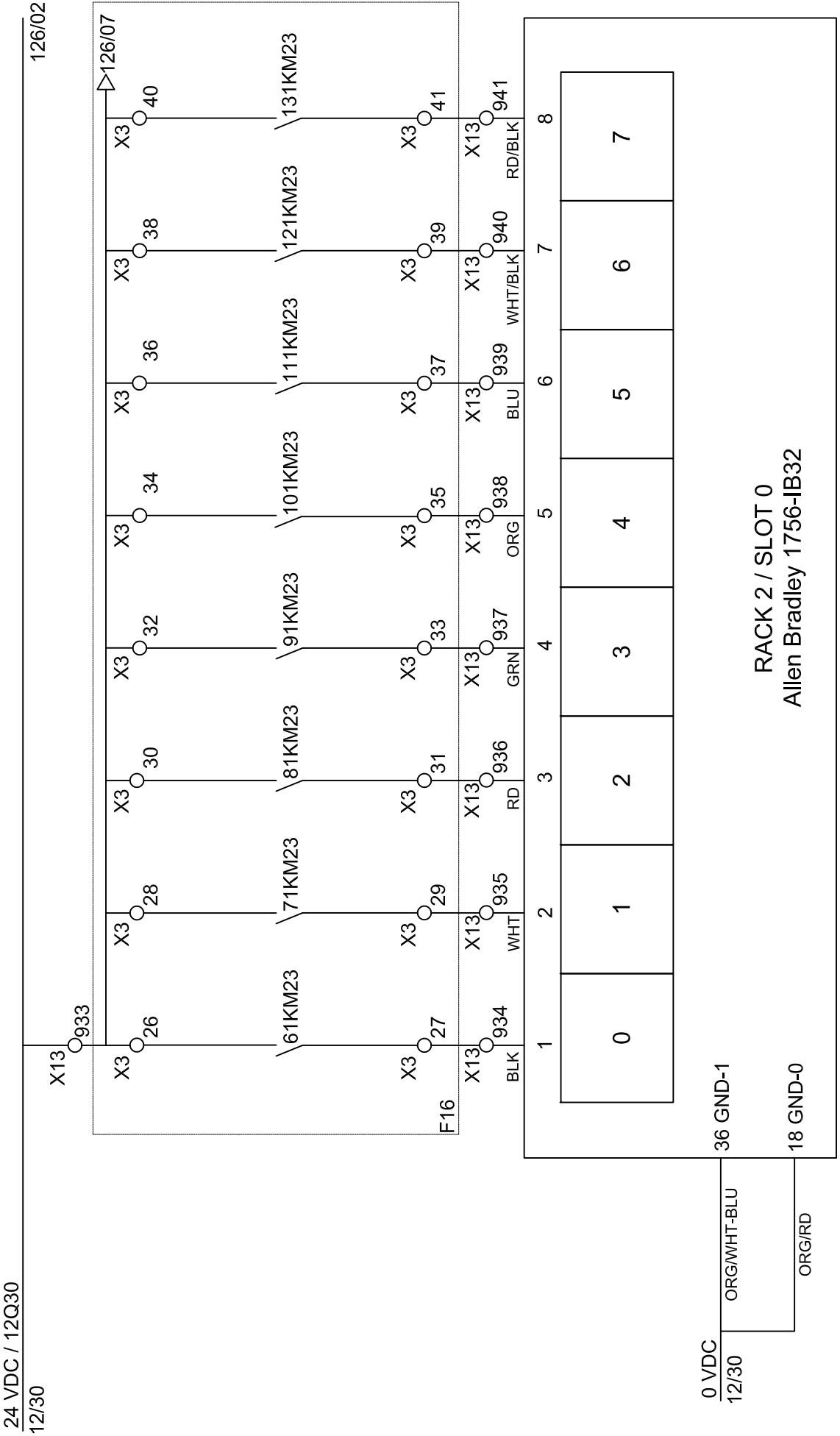


RACK 1 / SLOT 11
Allen Bradley 1756-IB32

|B5 0 |B5 1 |B5 2 |B5 3 |B5 4 |B5 5 |B5 6 |B5 7

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INTEPLAST GROUP, Ltd.																																		
AMTOFF DMI M/E DEPT.																																		
DRAWN BY	JEFF LEE																																	
CHECKED BY	VINCENT HUANG																																	
32 P.L.C. DIGITAL INPUT																																		
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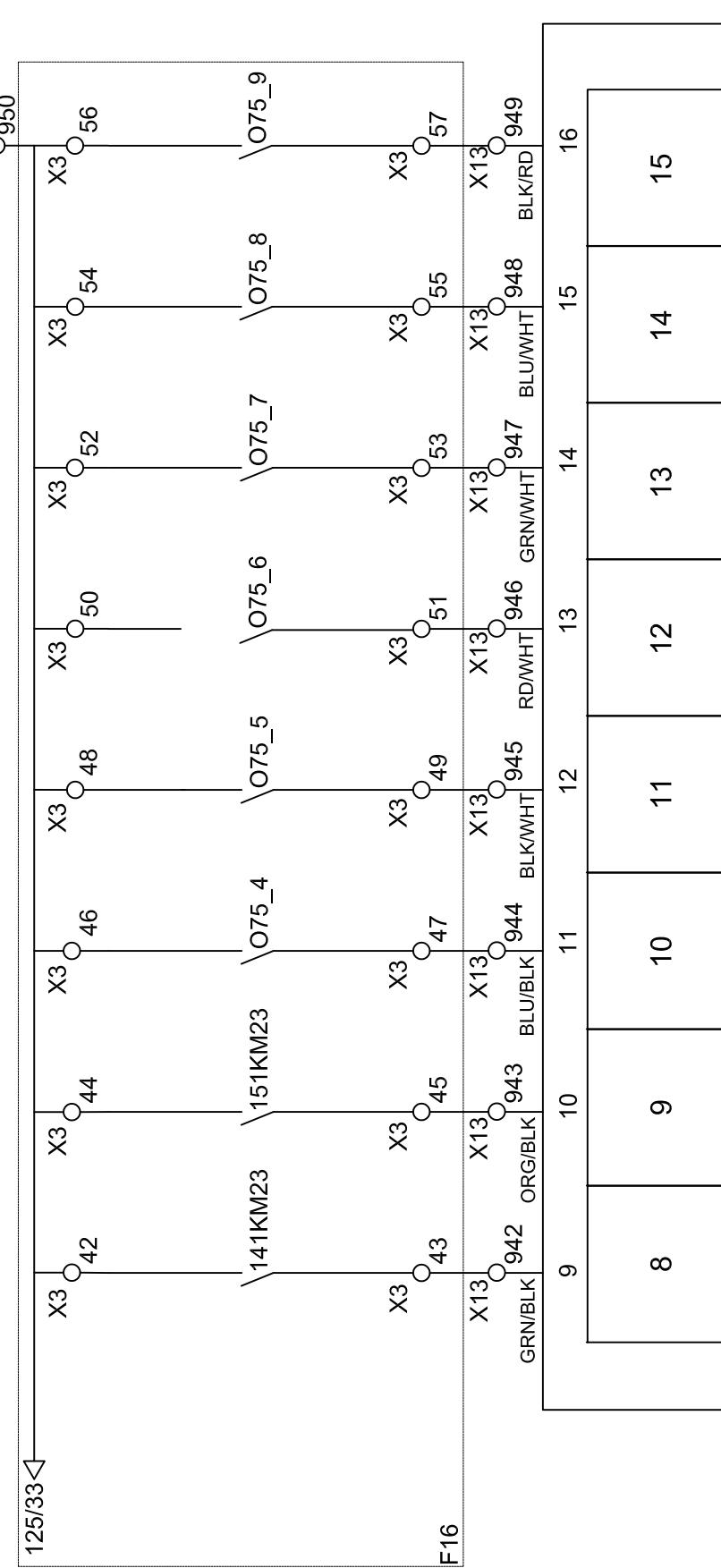
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125/34

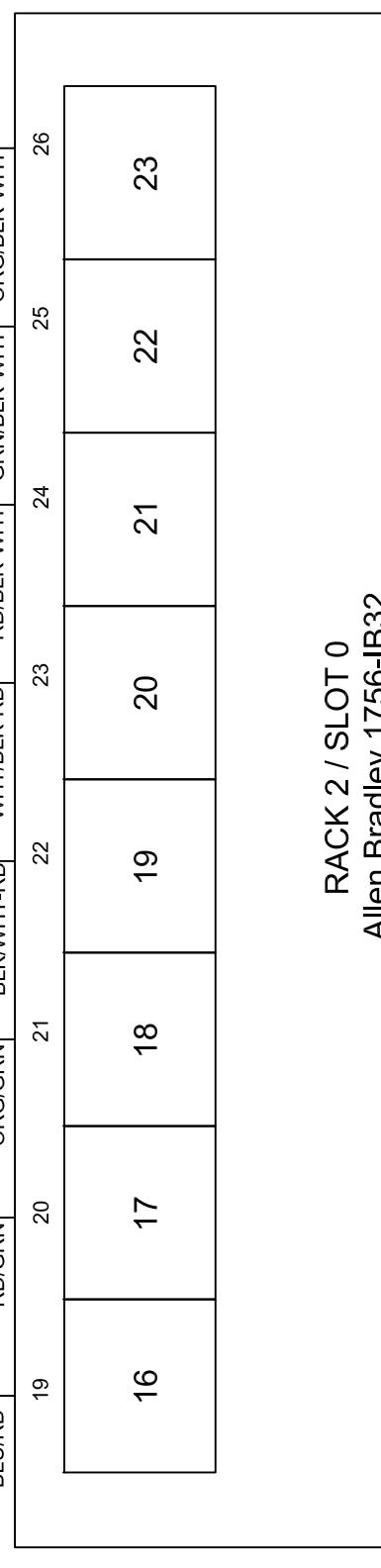
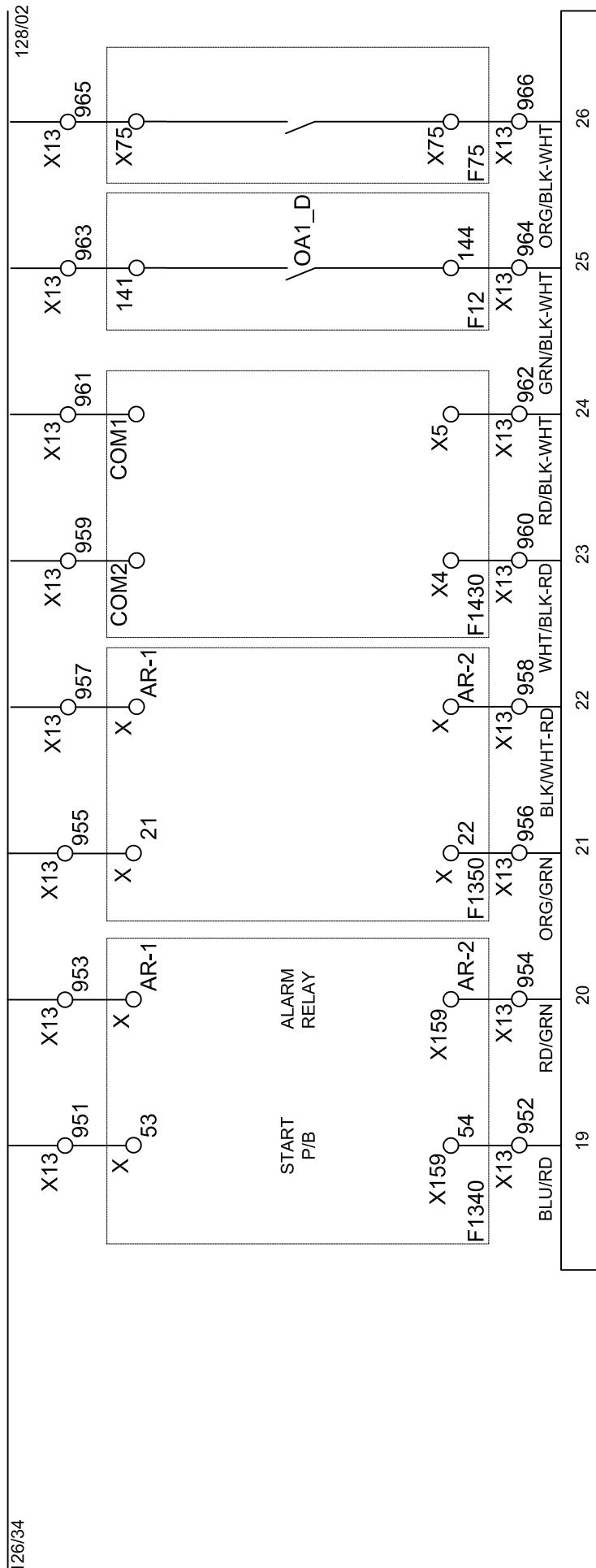
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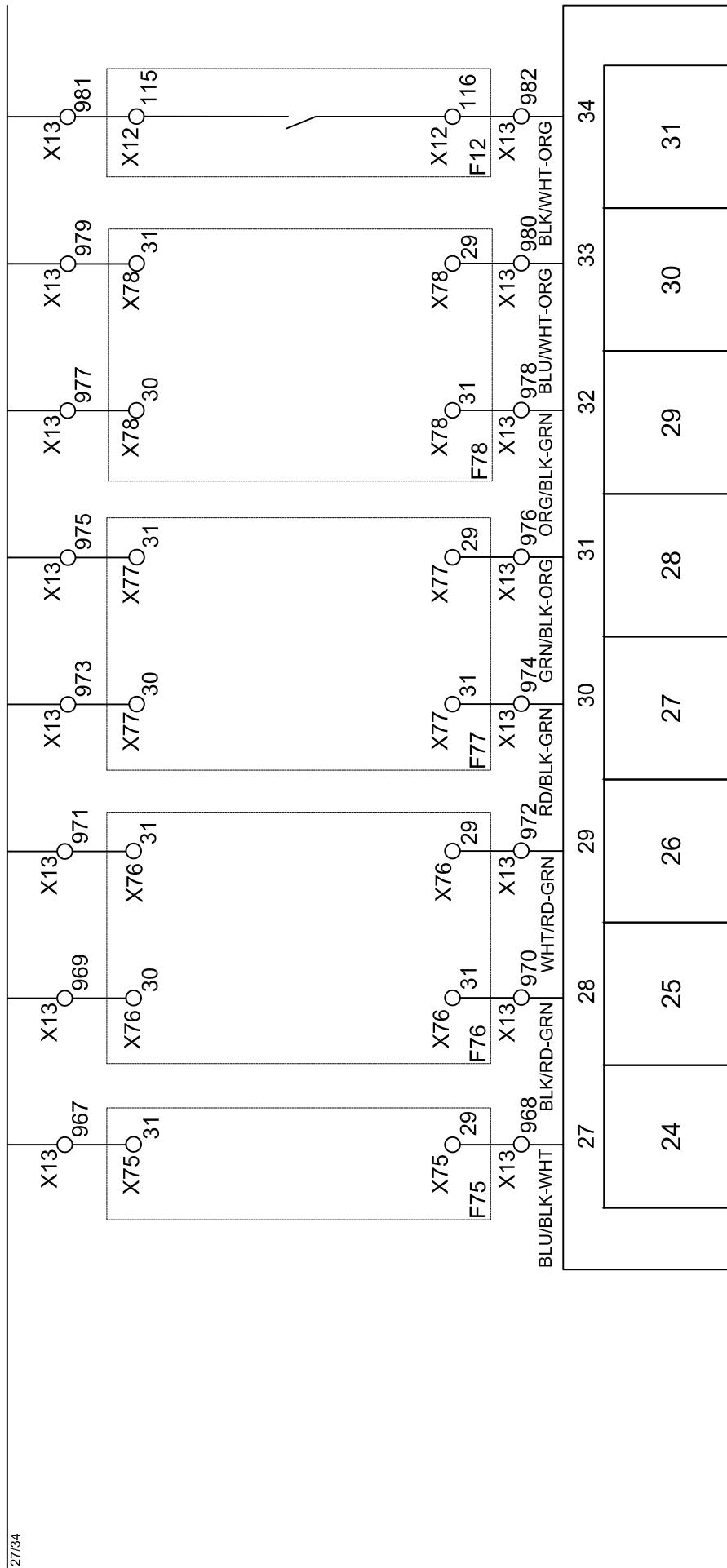


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Allen Bradley 1756-IE

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C.R. COOLING ON																																	





RACK 2 / SLOT 0
Allen Bradley 1756-IB

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32 P | C DIGITAL INPUT

32 P.L.C. DIGITAL INPUT

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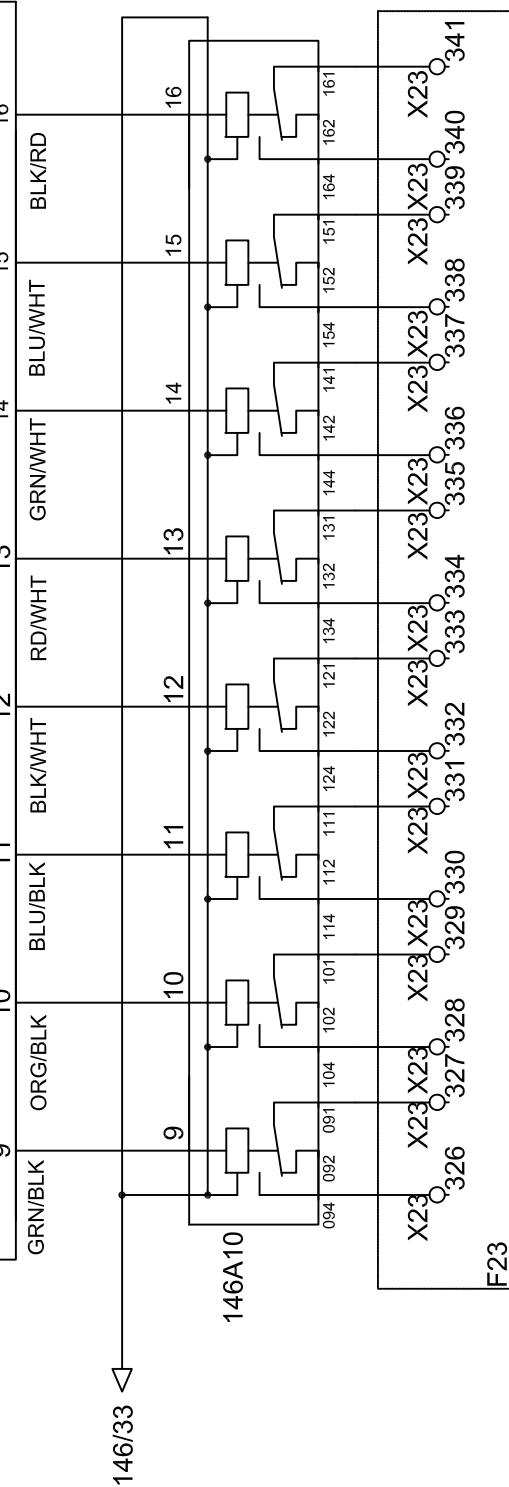
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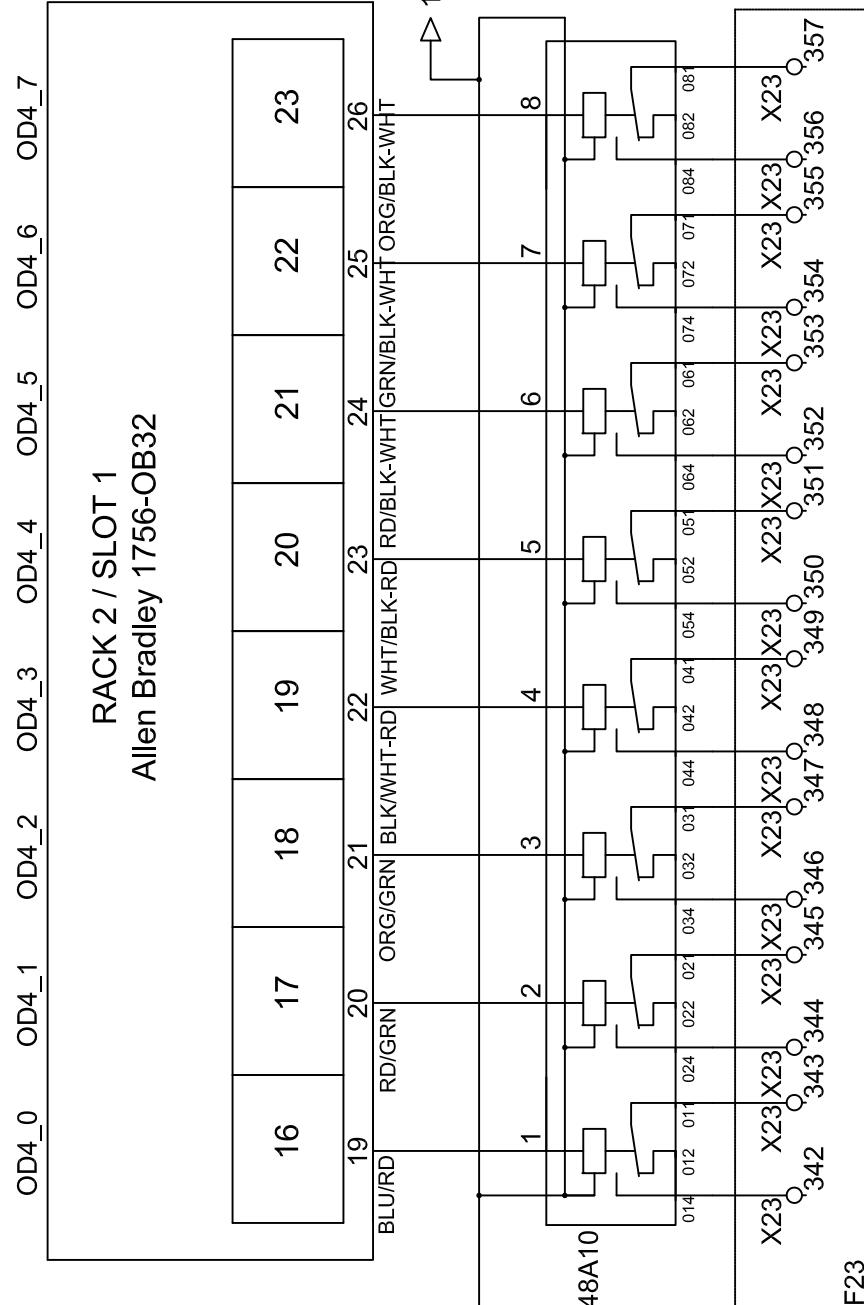
RACK 2 / SLOT 1
Allen Bradley 1756-OB32

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INTEPLAST GROUP, Ltd. AMTOPP DIV. MIE DEPT.	KF F13	Page # 147
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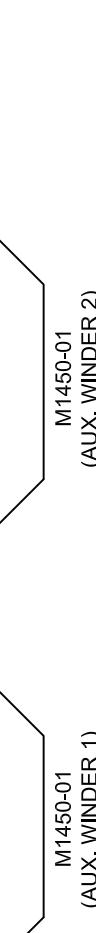
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INTEPLAST GROUP, Ltd. AMTOPP DIVI. MIE DEPT.															Page # 148																		
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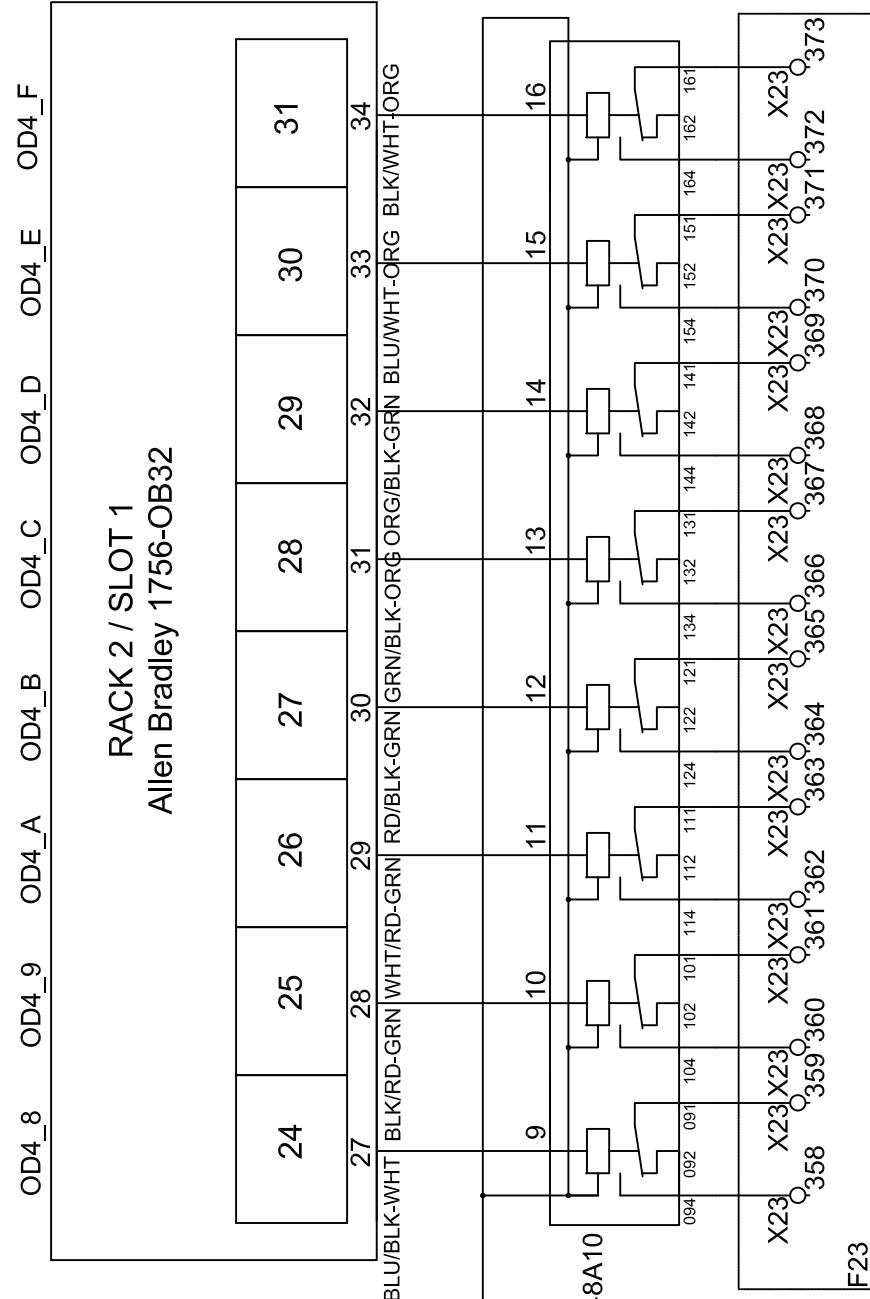
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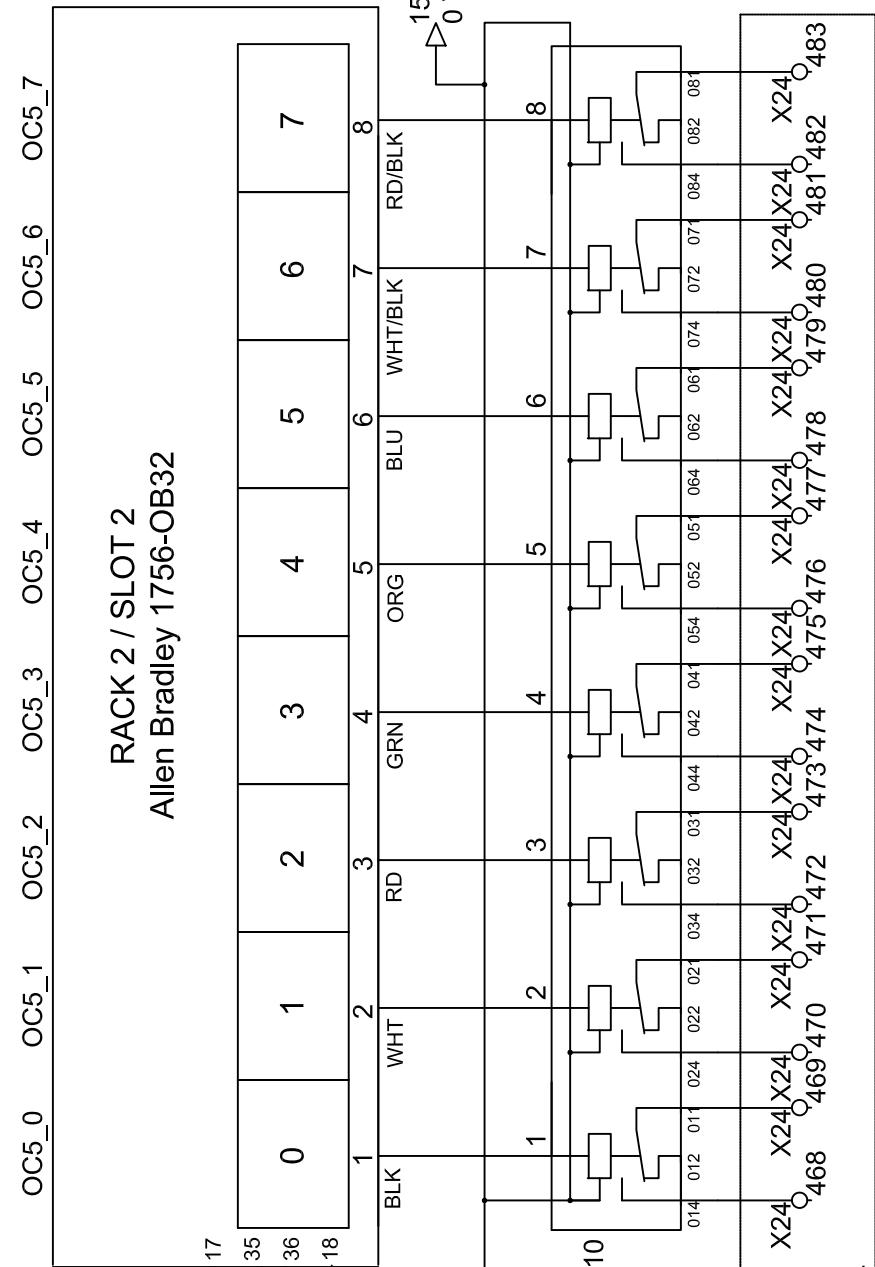
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M 1490-U
(AUX; WINDER 1)



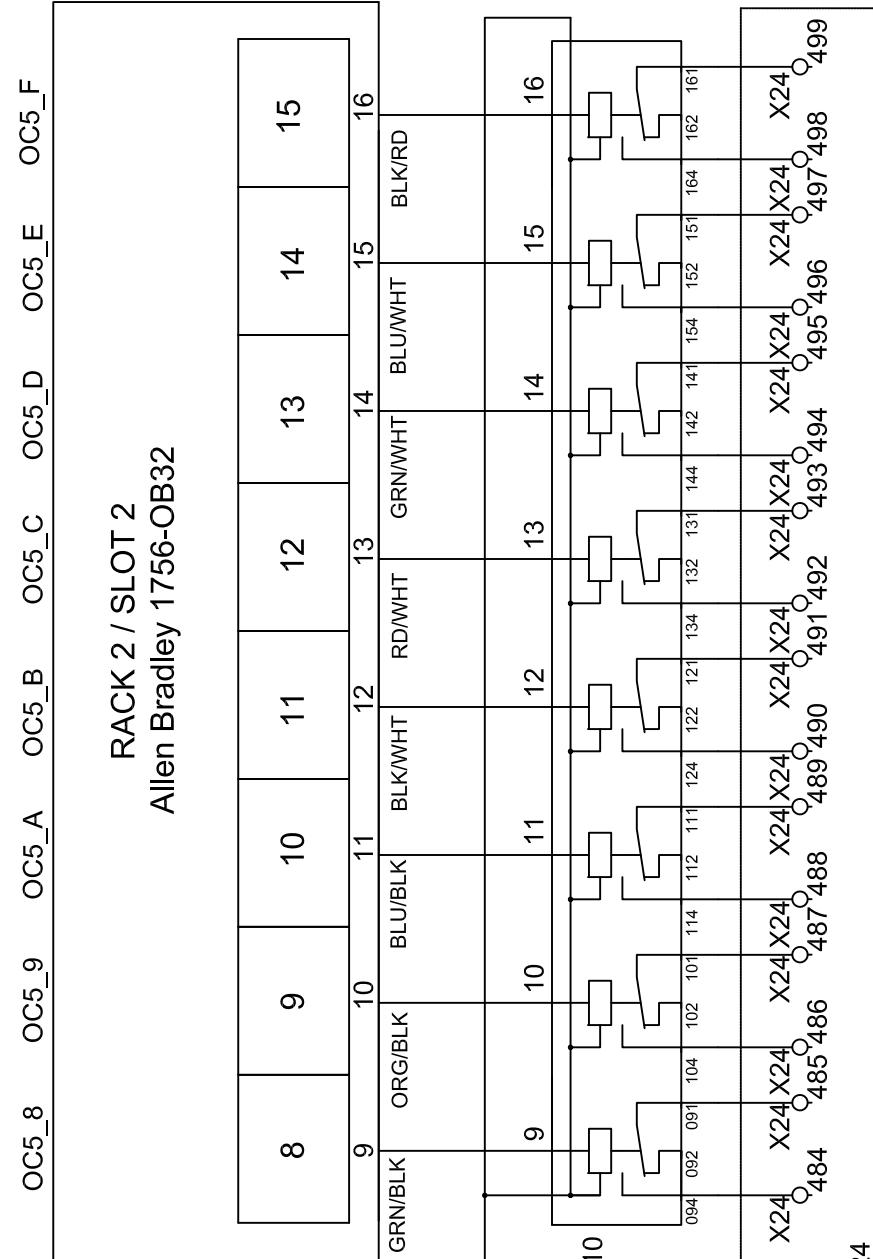
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CENT EXHAUST	CLIPS	CLIPS	COOLING	CLIPS	COOLING	NEVTRAL	TOP	FREE	AIR FAN	AIR FAN	NEVTRAL	ZONE	EXHAUST	EXHAUST	EXHAUST	EXHAUST	EXHAUST																
AIR FAN M1525-01	COOLING M1528-01	COOLING M1528-02	NEVTRAL ZONE EXHAUST																														
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32 P.L.C. DIGITAL OUTPUT

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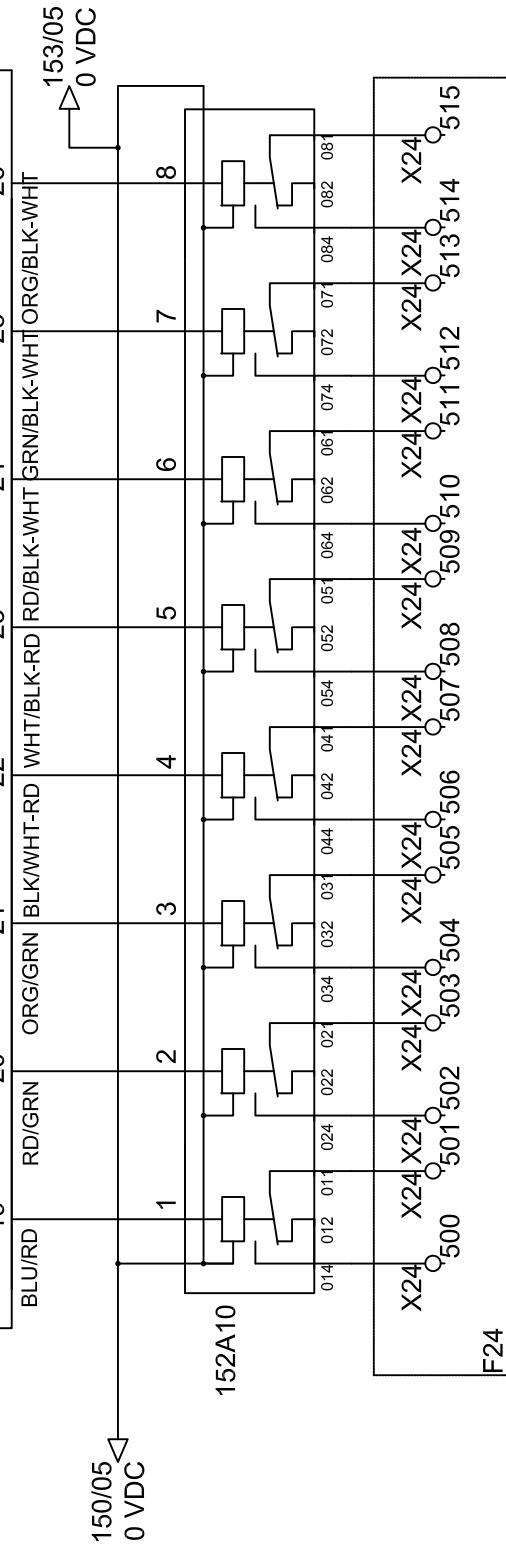
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RACK 2 / SLOT 2
Allen Bradley 1756-OB32

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CHECKED BY	VINCENT HUANG																																

32 P.L.C. DIGITAL OUTPUT

152

Total

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Page #

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152

1

UPGRADE TO AB

Eryan Hong

12/05/2023

DRAWING NO.

DRAWN DATE:

03-03-2014

REV. DATE

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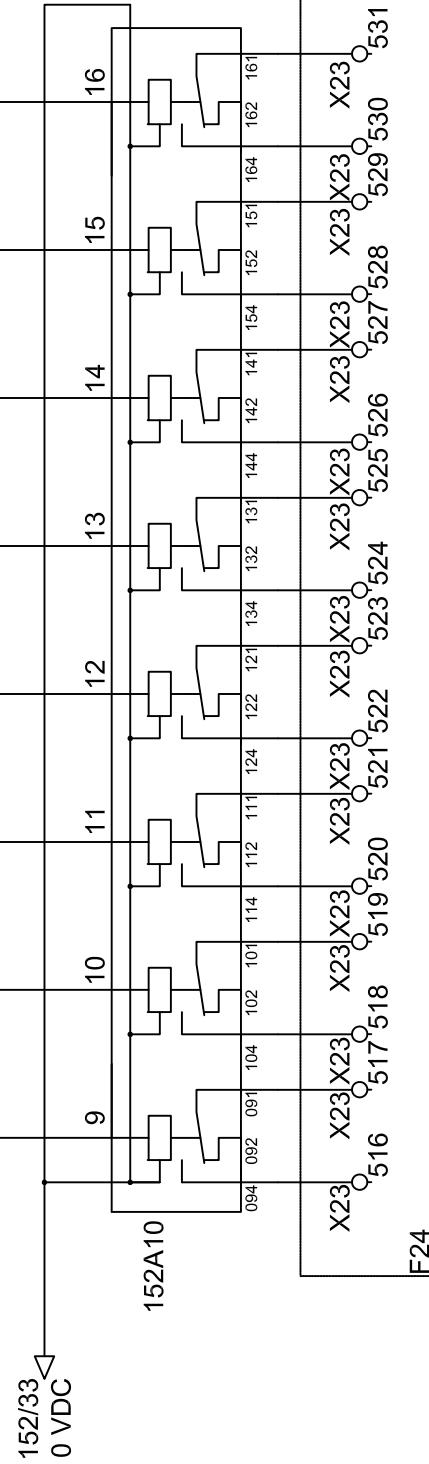
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RACK 2 / SLOT 2
Allen Bradley 1756-OB32

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CHECKED BY	VINCENT HUANG																																

32 P.L.C. DIGITAL OUTPUT



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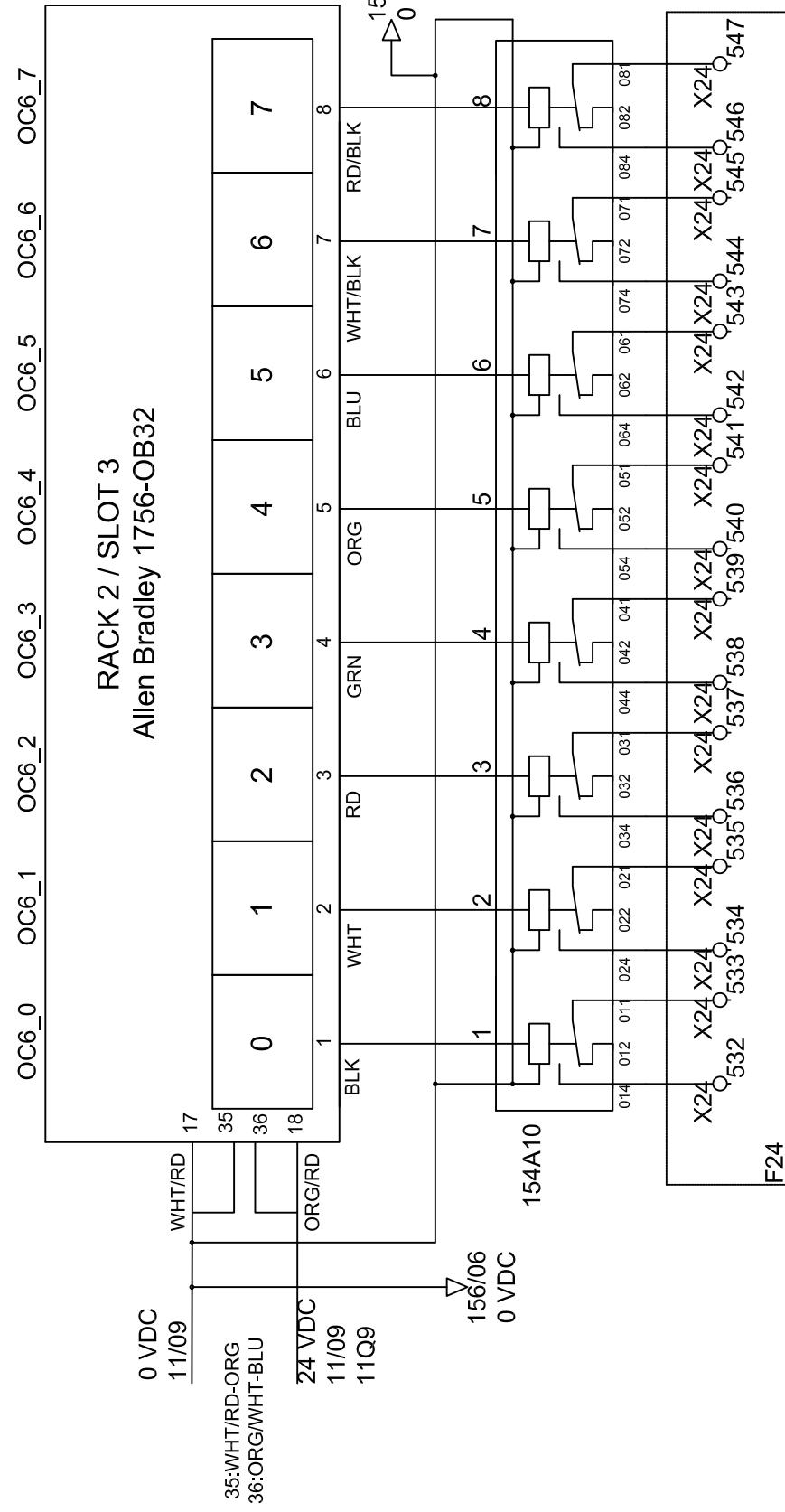
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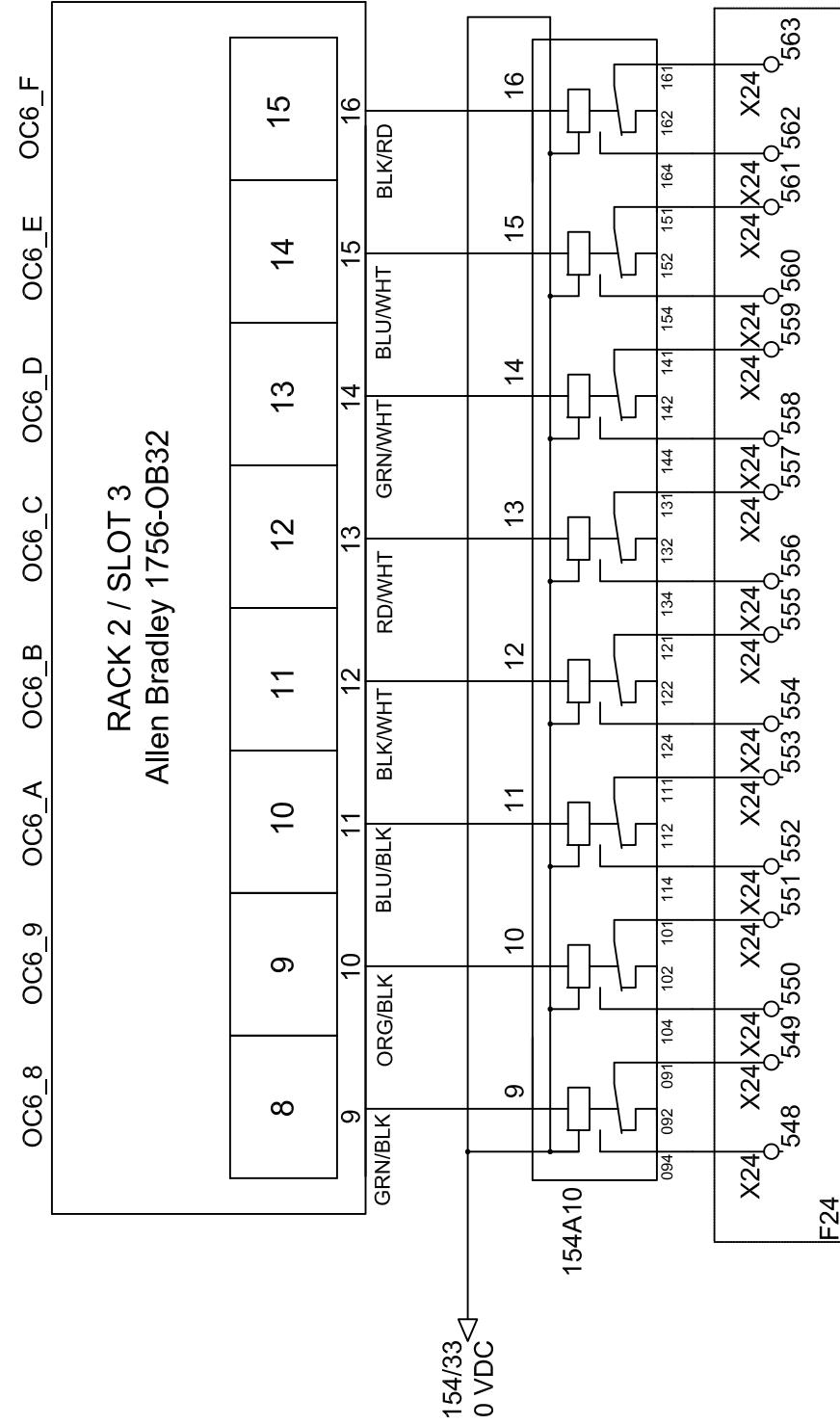
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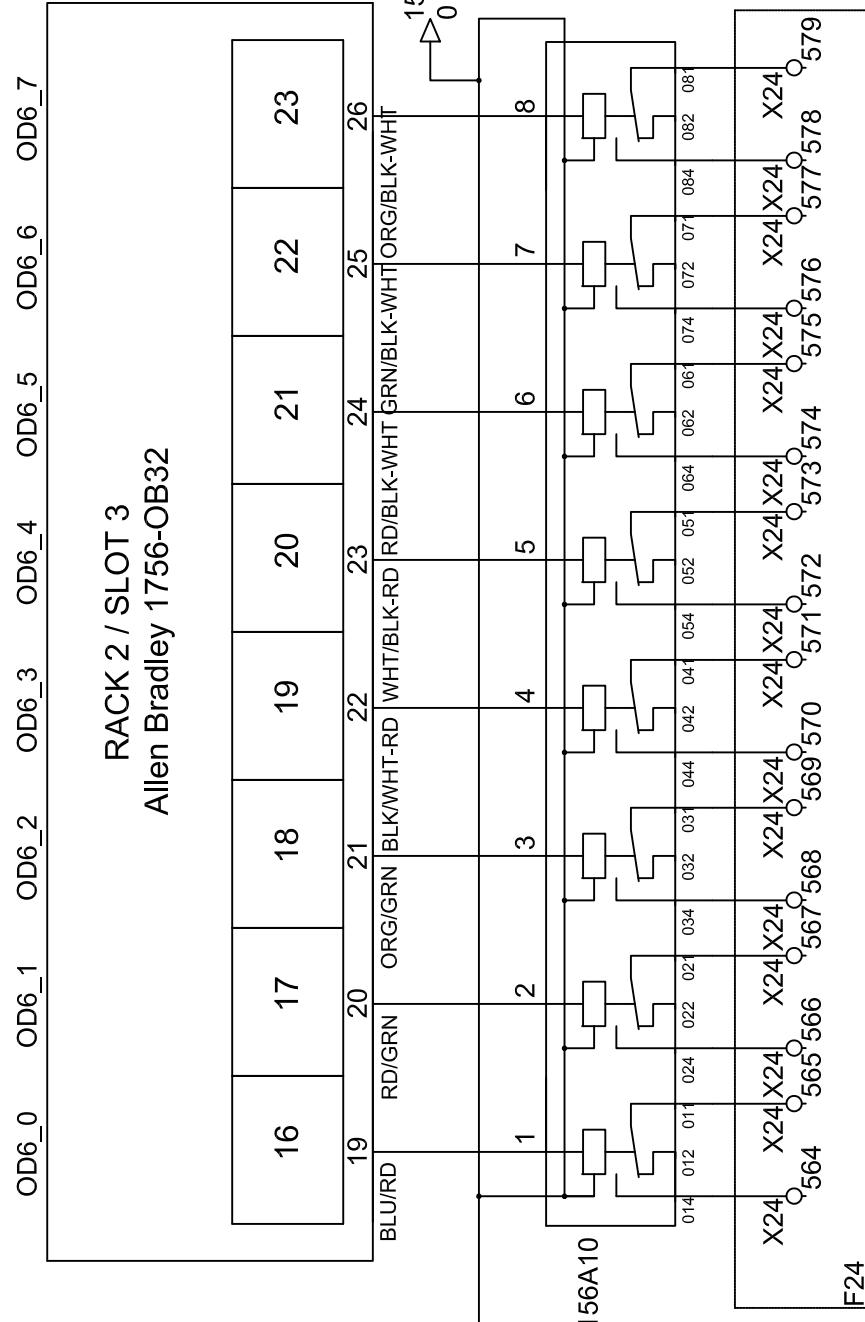
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32 P.L.C. DIGITAL OUTPUT



INTEPLAST GROUP, Ltd.
AMTOPP DIV., MIE DEPT.

DRAWN BY JEFF LEE

CHECKED BY VINCENT HUANG

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F13

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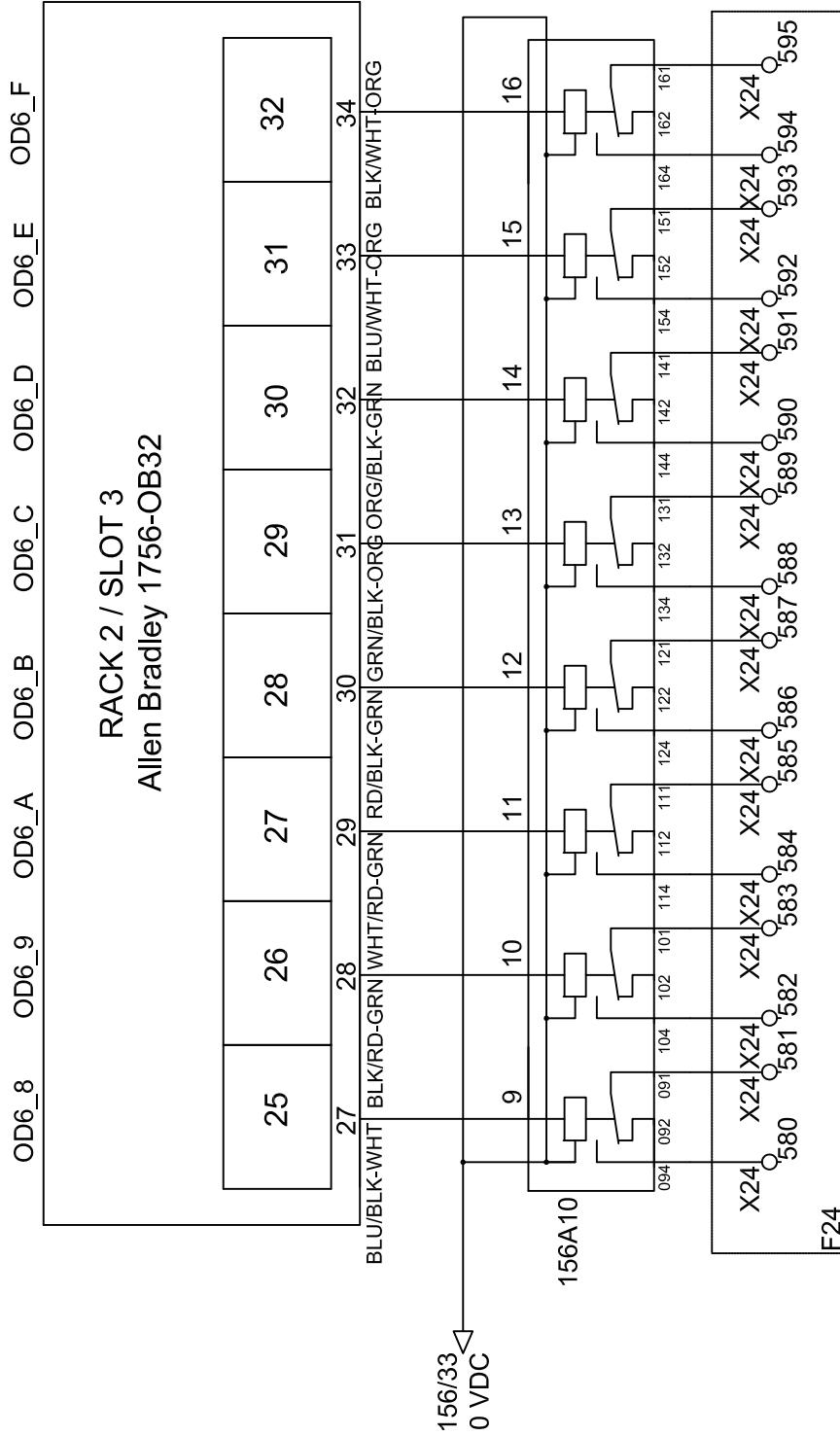
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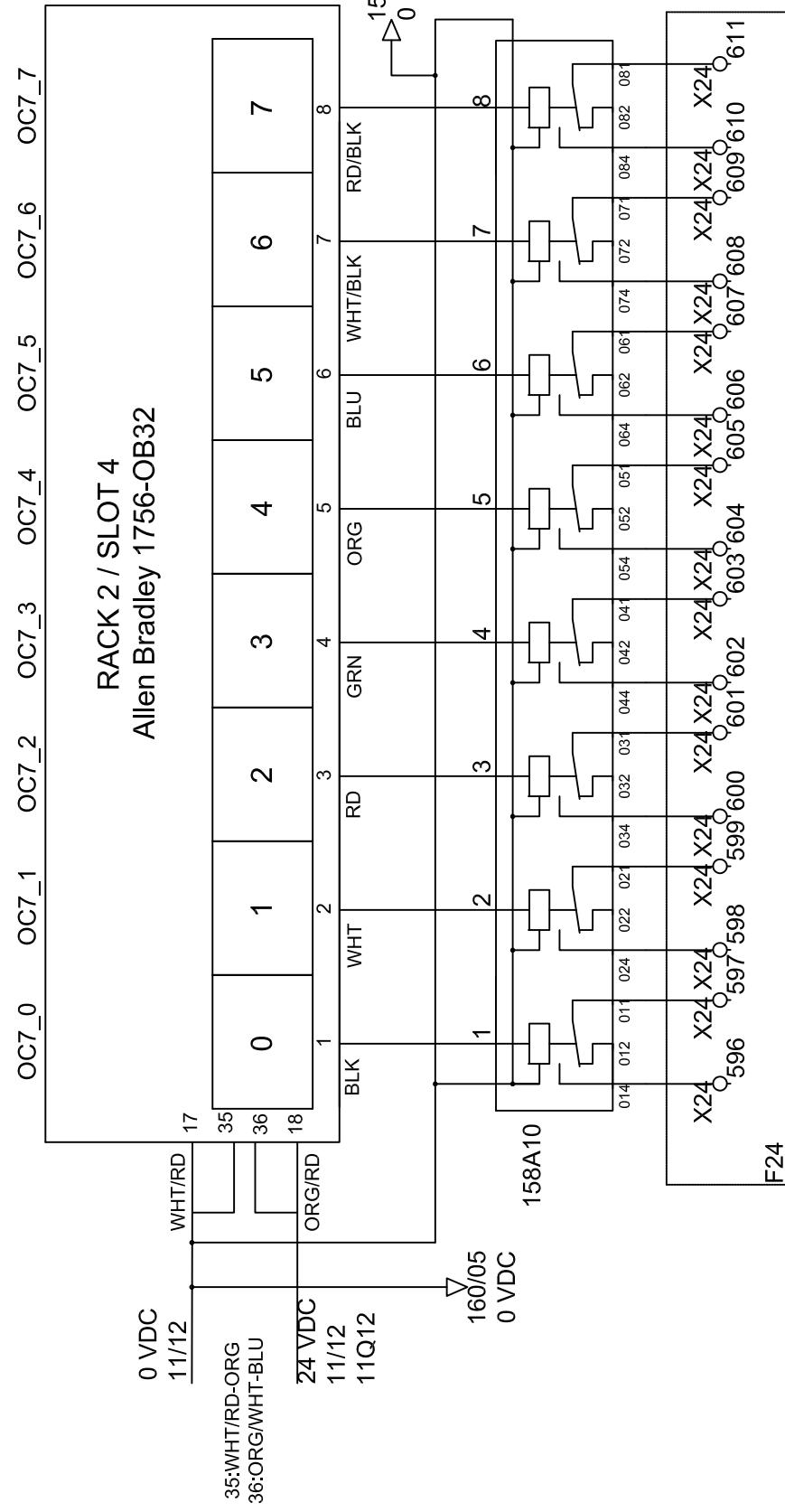
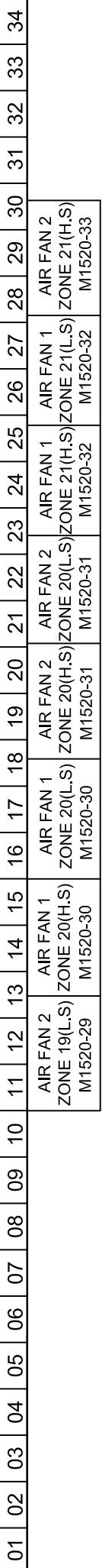
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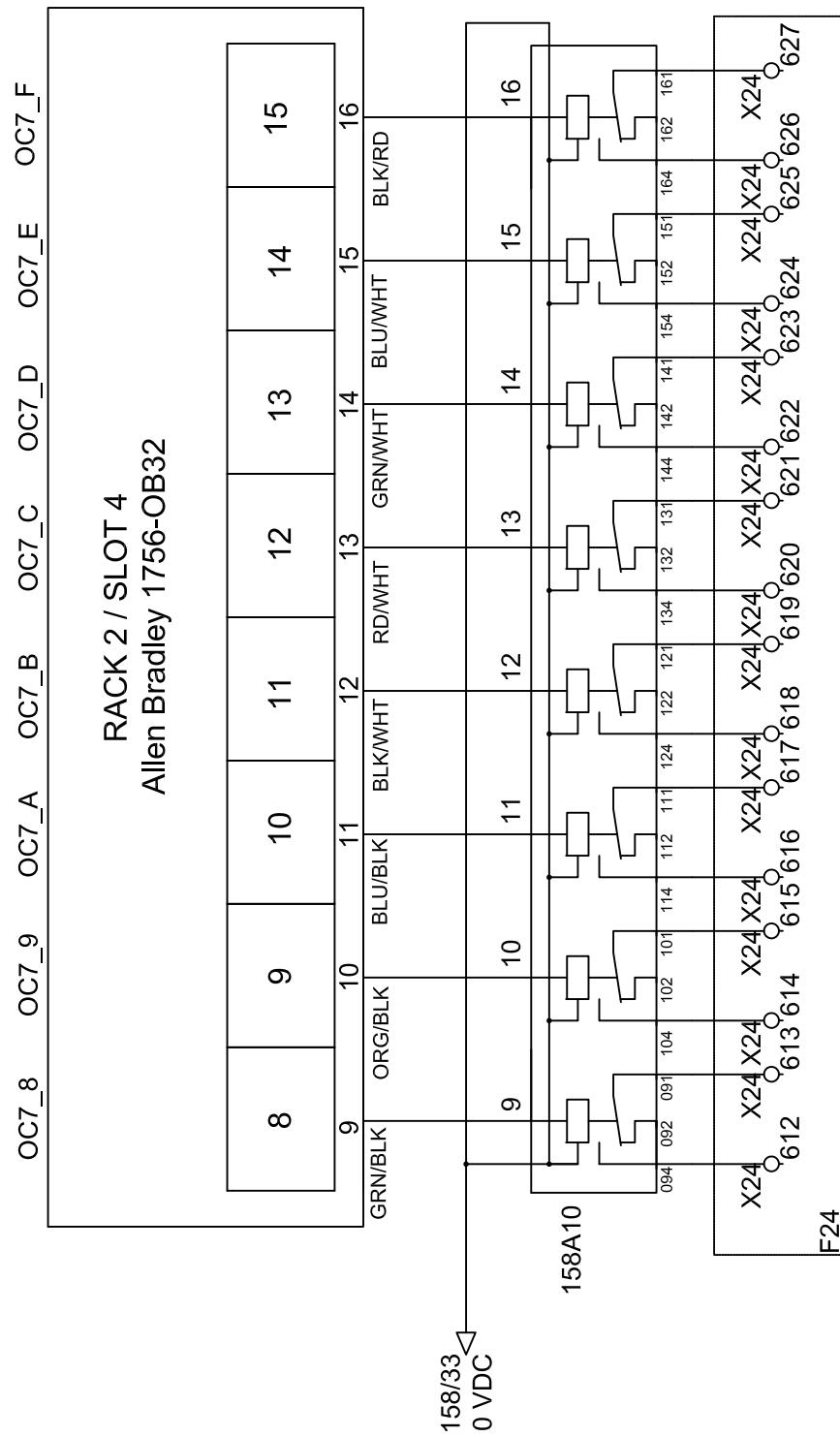


32 | C DIGITAL OUTPUT

INTEPLAST GROUP, Ltd.
AMTOPP DIV. ME DEPT.



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CHECKED BY	VINCENT HUANG																																
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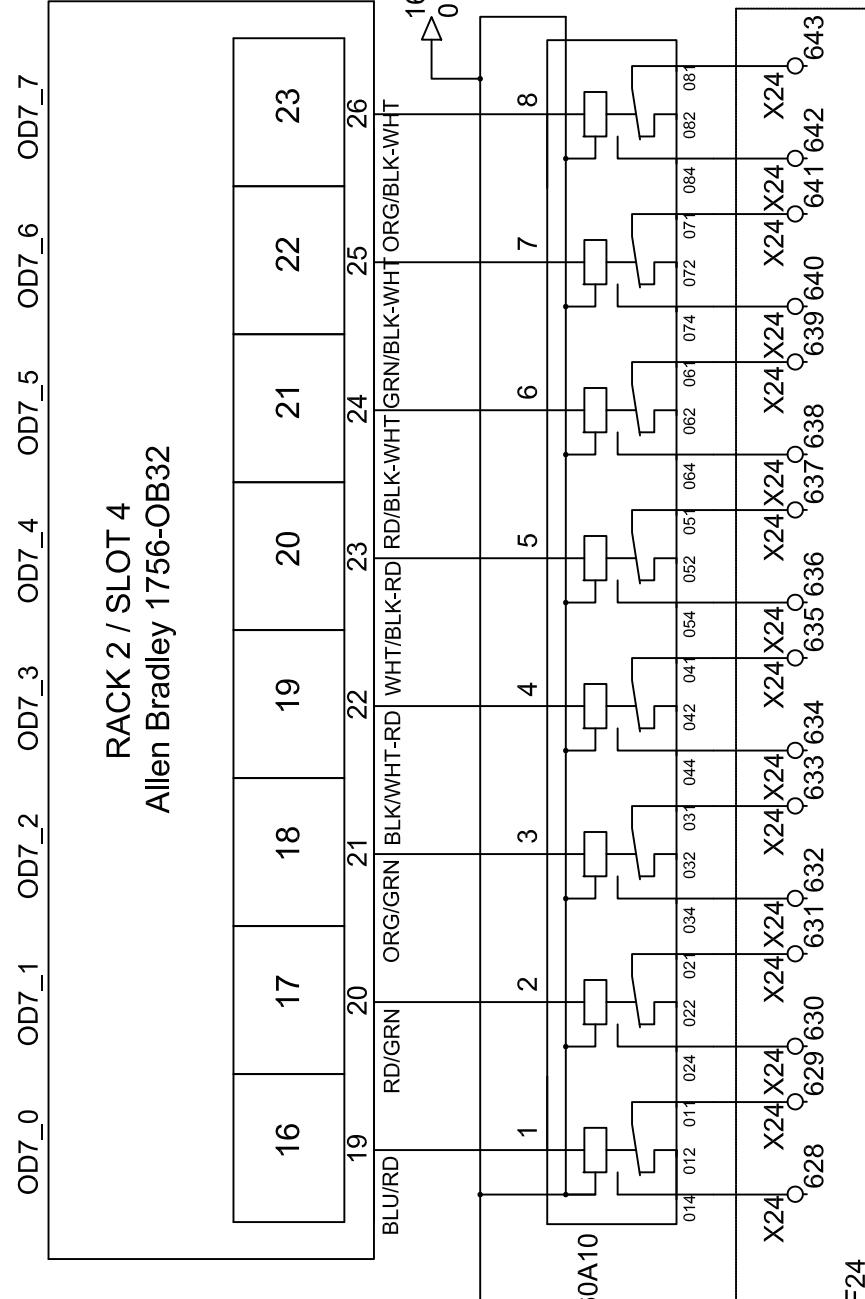


32 DEPARTAMENTO DE INVESTIGACIONES

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AMTOPP DIV. M/E DEPT.

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XEO FAN FOR F.T. EXHAUST																																					



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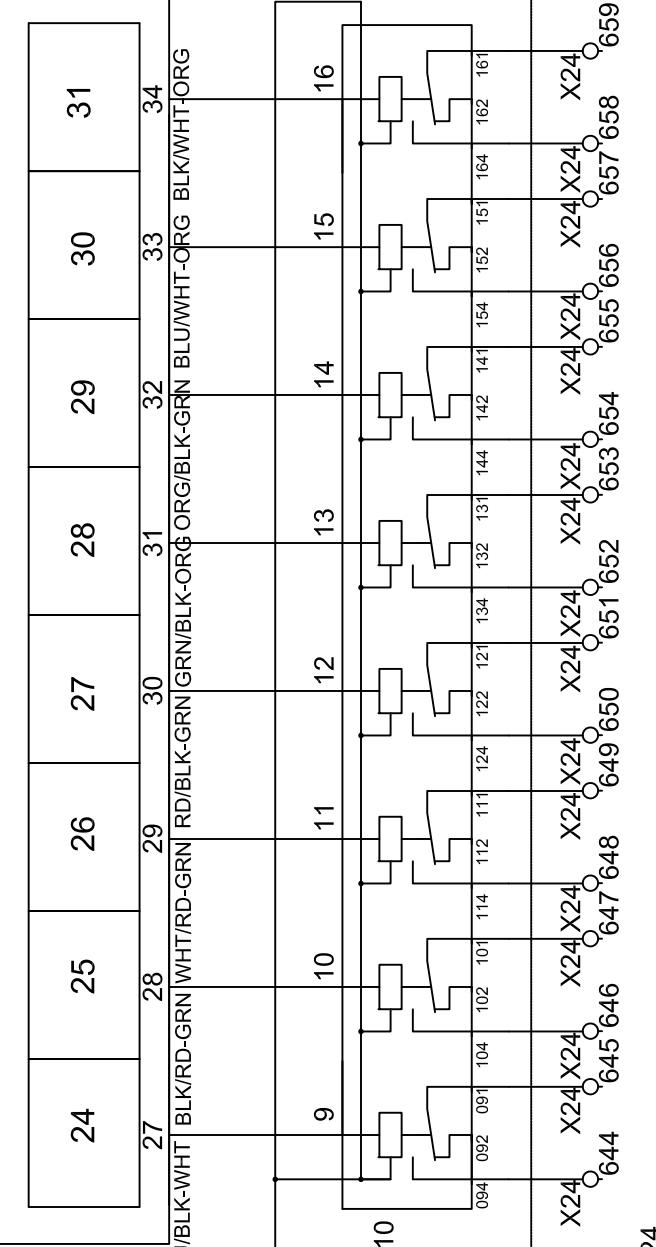
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FREE																																	

TO BRACKNER "ON" TDO DRIVE
PANEL TO BRACKNER
"FAULT PANEL
RESET" TO BRACKNER
PANEL
PANEL
"IN PRODUCTION"

OD7_8 OD7_9 OD7_A OD7_B OD7_C OD7_D OD7_E OD7_F

RACK 2 / SLOT 4
Allen Bradley 1756-OB32



01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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DRAWN BY	JEFF LEE																																
CHECKED BY	VINCENT HUANG																																

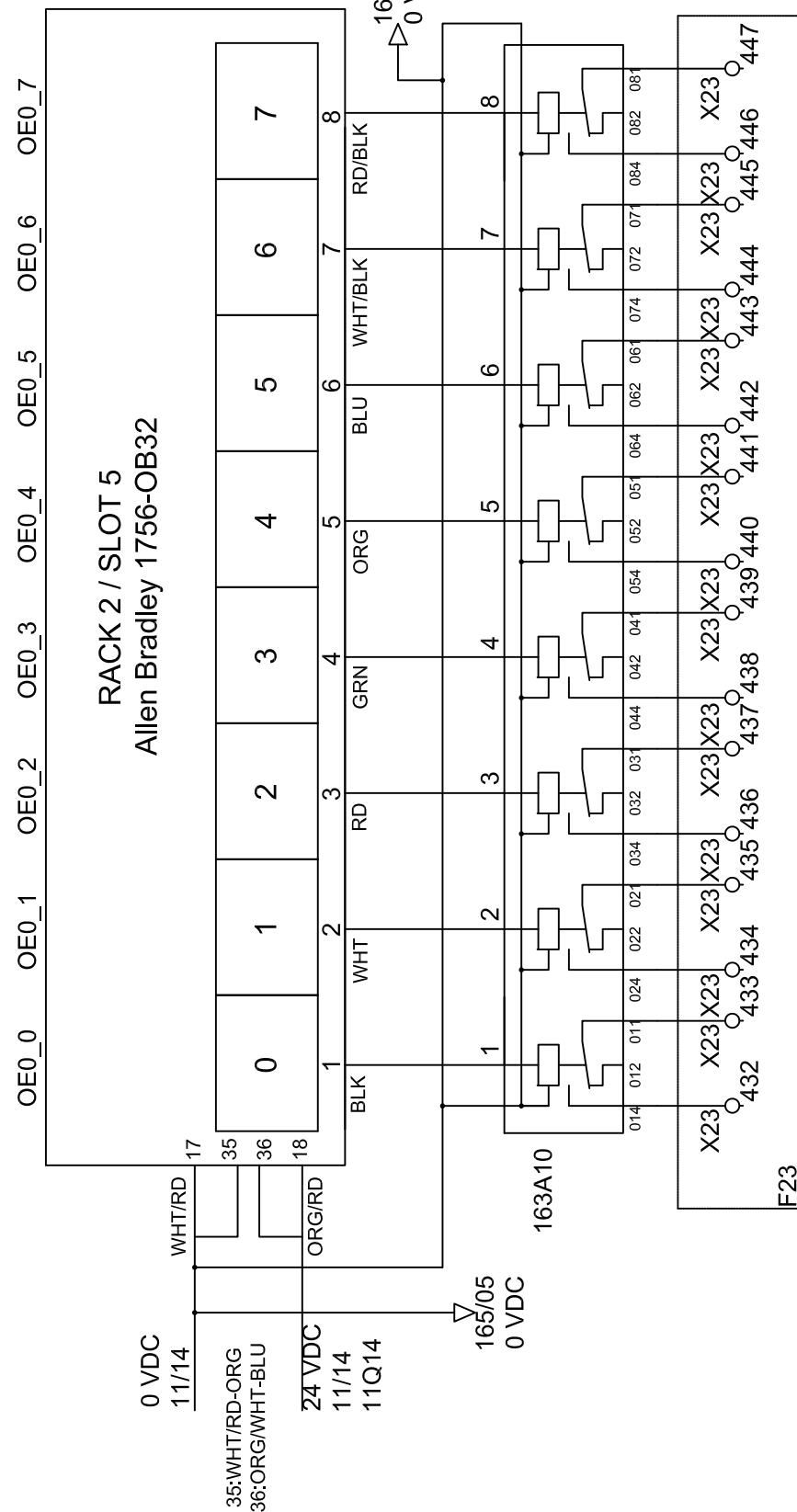
32 P.L.C. DIGITAL OUTPUT

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INTEPLAST GROUP - Ltd. AMTOPP DIVI. M/E DEPT.	DRAWN BY	CHECKED BY	REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	03-03-2014	Page #	Total	MATERIAL	SCALE	UNIT	MM
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C.R. BRAKE	C.R.	BACKWARD	C.R.	FORWARD	C.R.	HIGH SPEED	C.R.	LOW SPEED	C.R.	DRAW ROLL																							
M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01		M1301-01	



	INTEPLAST GROUP, Ltd. AMTOPP DIVI. MIE DEPT.																											
DRAWN BY	JEFF LEE																											
CHECKED BY	VINCENT HUANG																											
REV. NO	REV. DESCRIPTION	REV. BY	REV. DATE	DRAWN DATE:	03-03-2014																							

32 P.L.C. DIGITAL OUTPUT

Page #

163

Total

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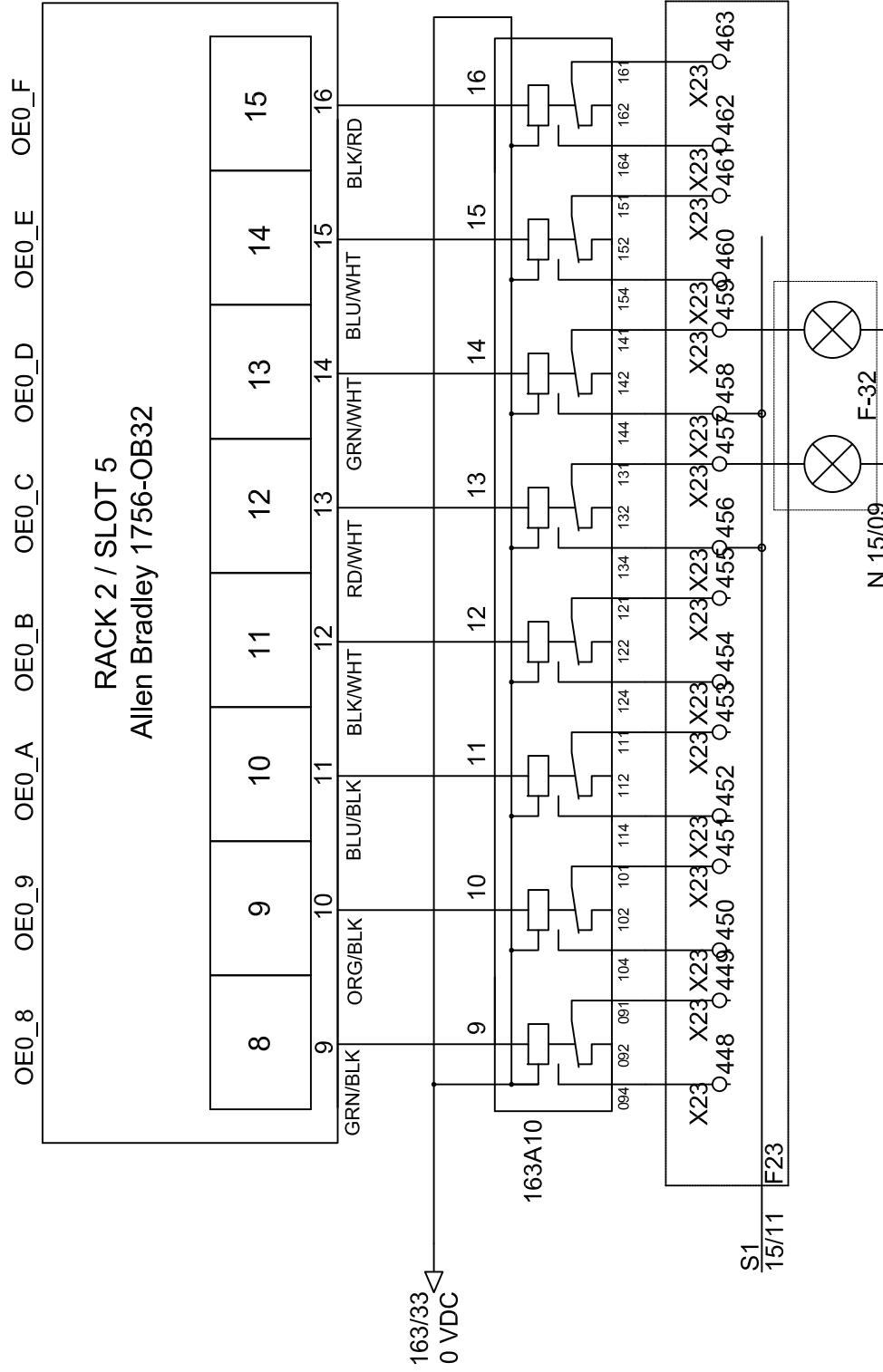
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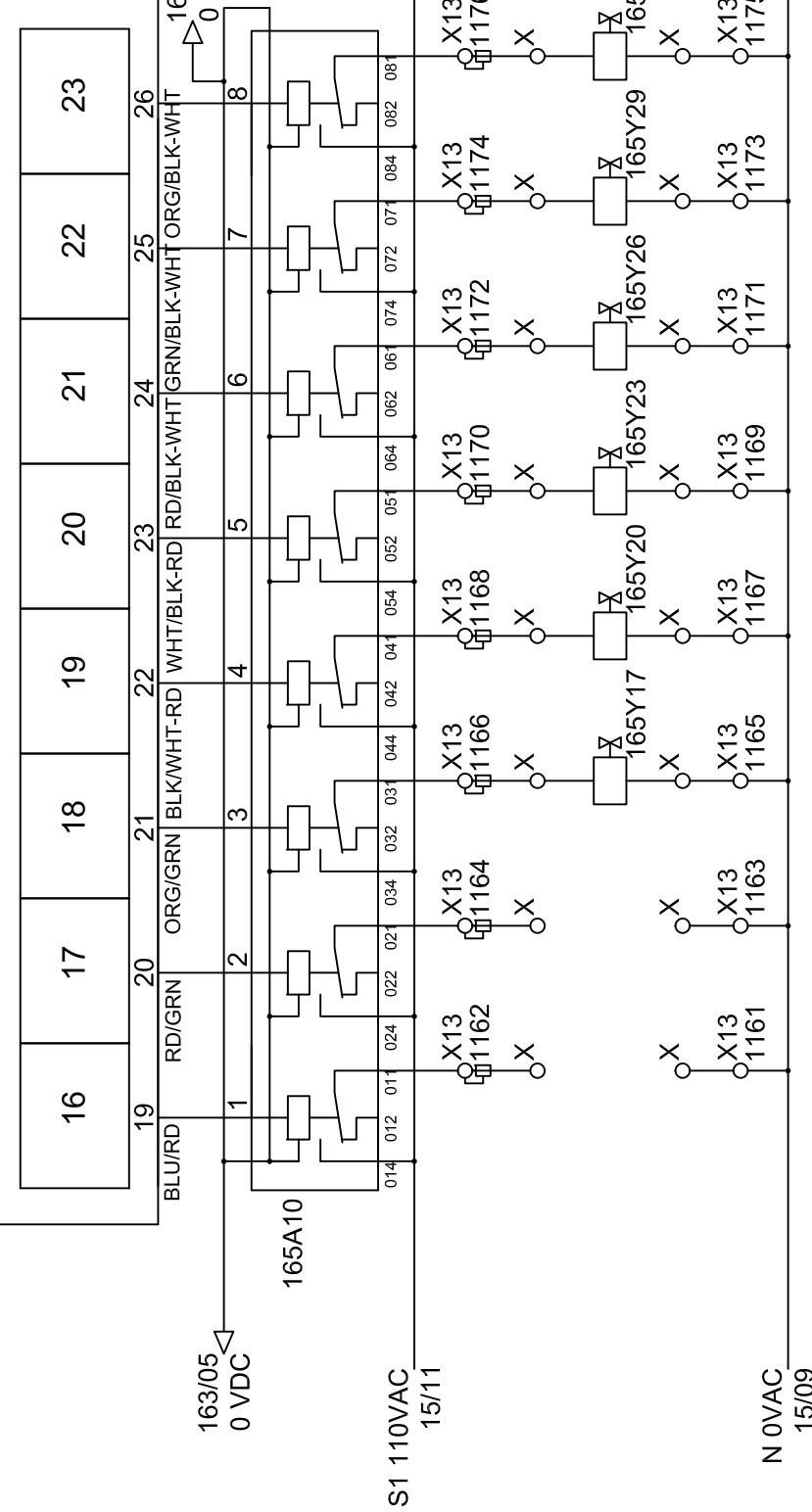
GREEN LAMP RED LAMP



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FREE	FREE	MDO ZONE 0	MDO ZONE 10	MDO ZONE 1	MDO ZONE 2	MDO ZONE 3	MDO ZONE 4																										
		SV1435-13	SV1435-14	SV1435-01	SV1435-02	SV1435-03	SV1435-04																										

OF0_0 OF0_1 OF0_2 OF0_3 OF0_4 OF0_5 OF0_6 OF0_7

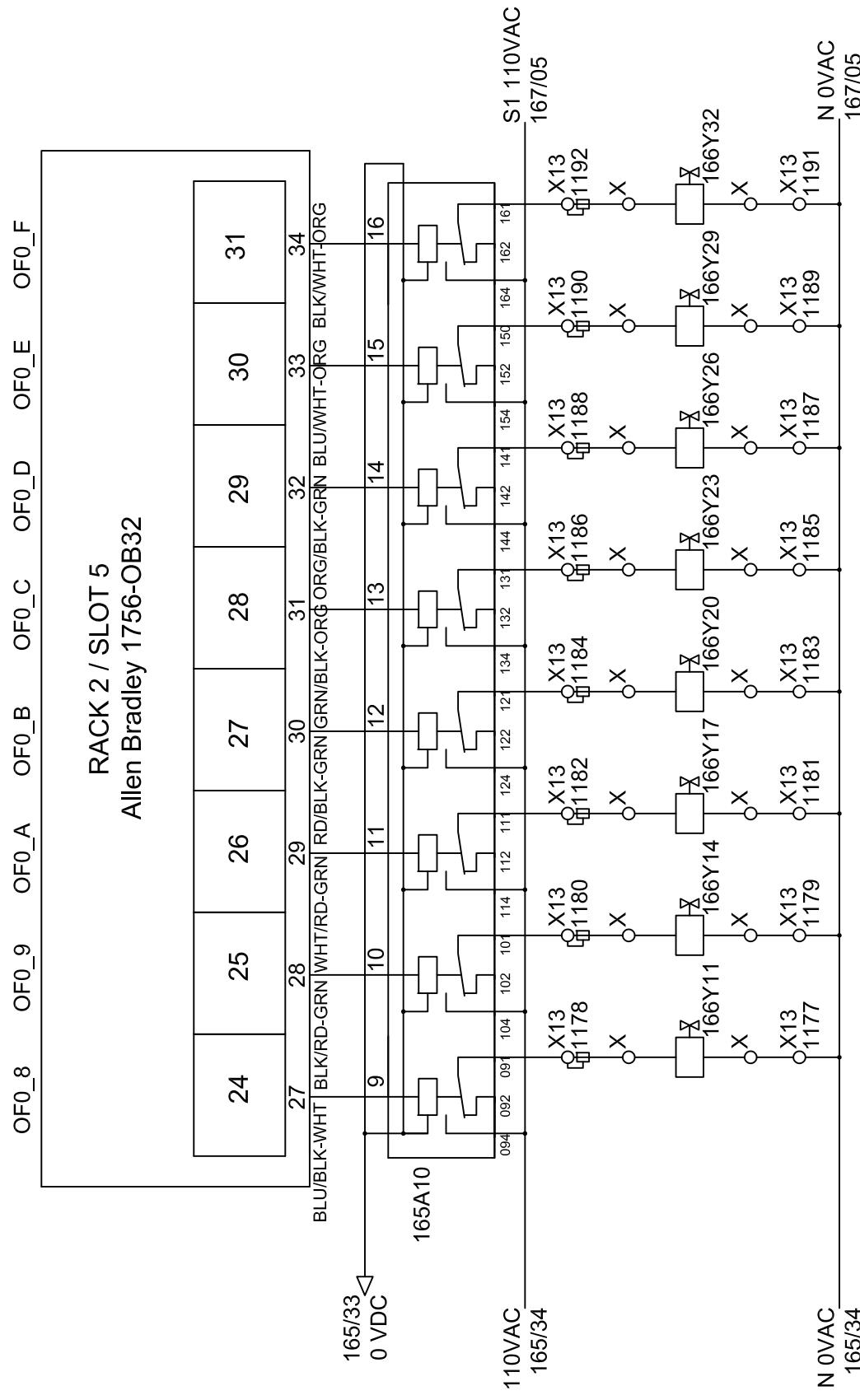
RACK 2 / SLOT 5
Allen Bradley 1756-OB32



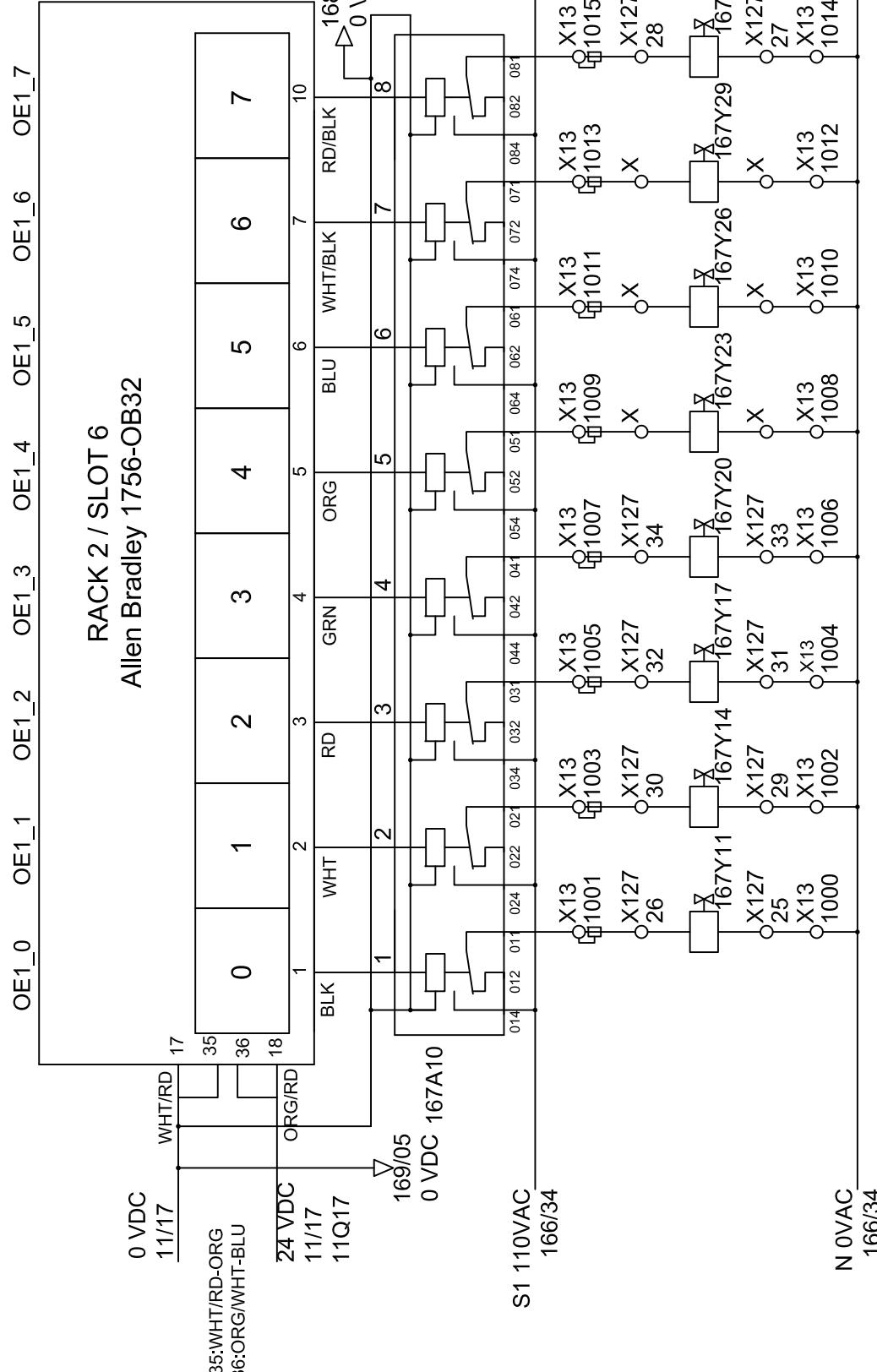
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INTEPLAST GROUP, Ltd. AMTOPP DIV. MIE DEPT.																																	
DRAWN BY	JEFF LEE																																
CHECKED BY	VINCENT HUANG																																

32 P.L.C. DIGITAL OUTPUT

1	UPGRADE TO AB	Eryan Hong	12/06/2023	DRAWING NO.	KF	DRAWING DESCRIPTION	F13	Page #	165
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				03-03-2014	MATERIAL				
					SCALE	NONE	UNIT	MM	



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AIR KNIFE POS. SV1310-09	ROLL POS SV1310-11	CHRUMLO ROLL POS. SV1310-12	CHRUMLO ROLL POS. SV1310-13	RUBBER ROLL POS. SV1350-03	AUX. WINDER NUM.1 ENG. SV1360-04	AUX. WINDER NUM.1 RETR. SV1360-05	AUX. WINDER EDGE PINNING SV1310-10																											
WATER BATH																																		
0 VDC 11/17	WHT/RD 11Q17	ORG/RD 36:ORG/WHT-BLU	BLK 167A10	WHT 169/05 0 VDC	RD 167Y11	RD 167Y14	RD 167Y17	RD 167Y20	RD 167Y23	RD 167Y26	RD/BLK 167Y29	RD/BLK 167Y32	RD/BLK 168/05 0 VDC	RD/BLK 168/05 S1 110VAC	RD/BLK 168/05 N 0VAC 166/34	RD/BLK 168/05 N 0VAC 166/34																		
35:WHT/RD-ORG 36:ORG/WHT-BLU	0 VDC 11/17	0 VDC 11Q17	0 VDC 167A10	0 VDC 169/05	0 VDC 167Y11	0 VDC 167Y14	0 VDC 167Y17	0 VDC 167Y20	0 VDC 167Y23	0 VDC 167Y26	0 VDC 167Y29	0 VDC 167Y32	0 VDC 168/05 S1 110VAC	0 VDC 168/05 N 0VAC 166/34																				



32 P.L.C. DIGITAL OUTPUT

REV. NO	REV. DESCRIPTION	DRAWING NO.	DRAWING DESCRIPTON	KF	Page #
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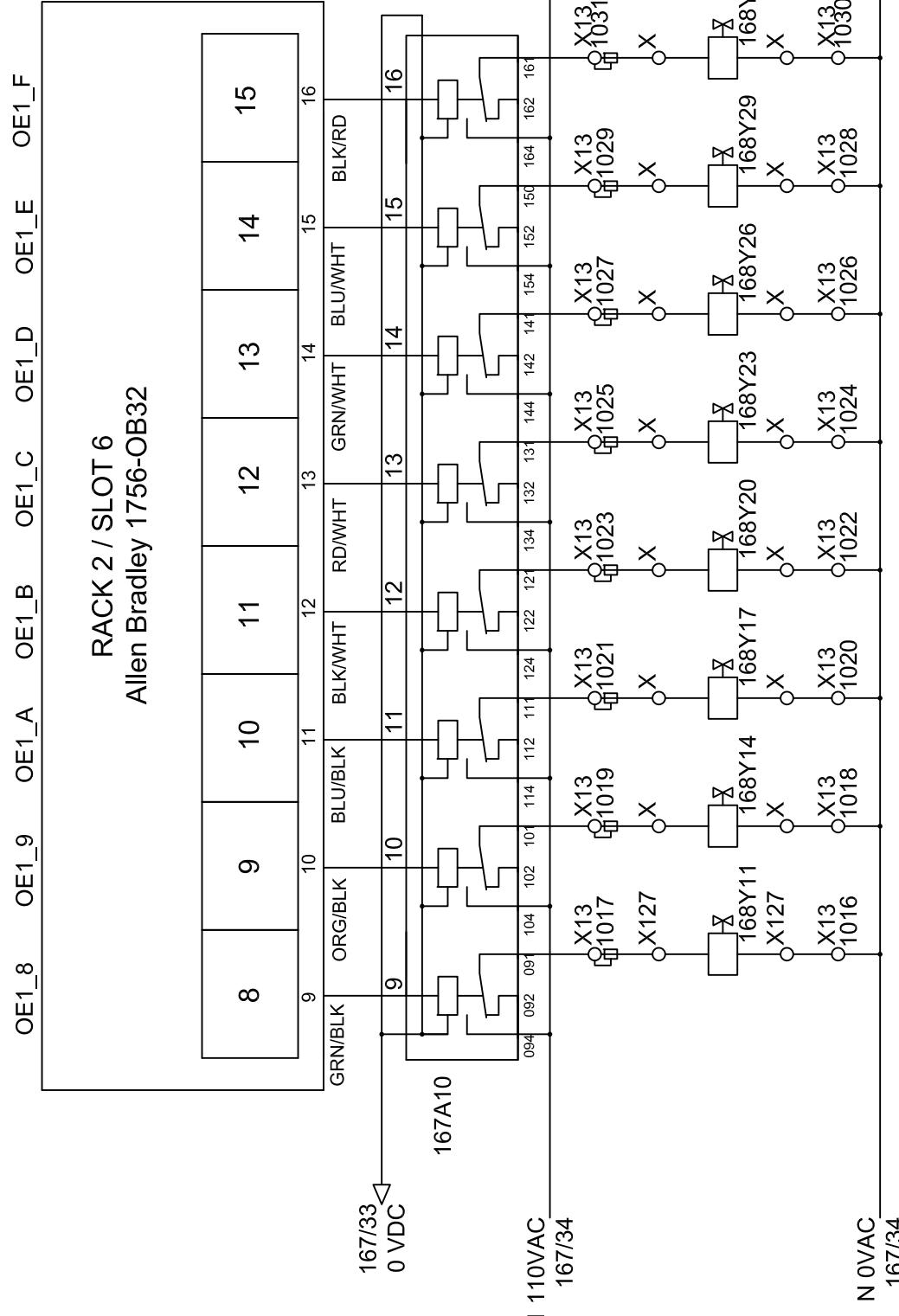
INTEPLAST GROUP, Ltd.
AMTOPP DIVI. MIE DEPT.

DRAWN BY JEFF LEE

CHECKED BY VINCENT HUANG

03-03-2014 DRAWN DATE:

03-03-2014 REV. DATE:

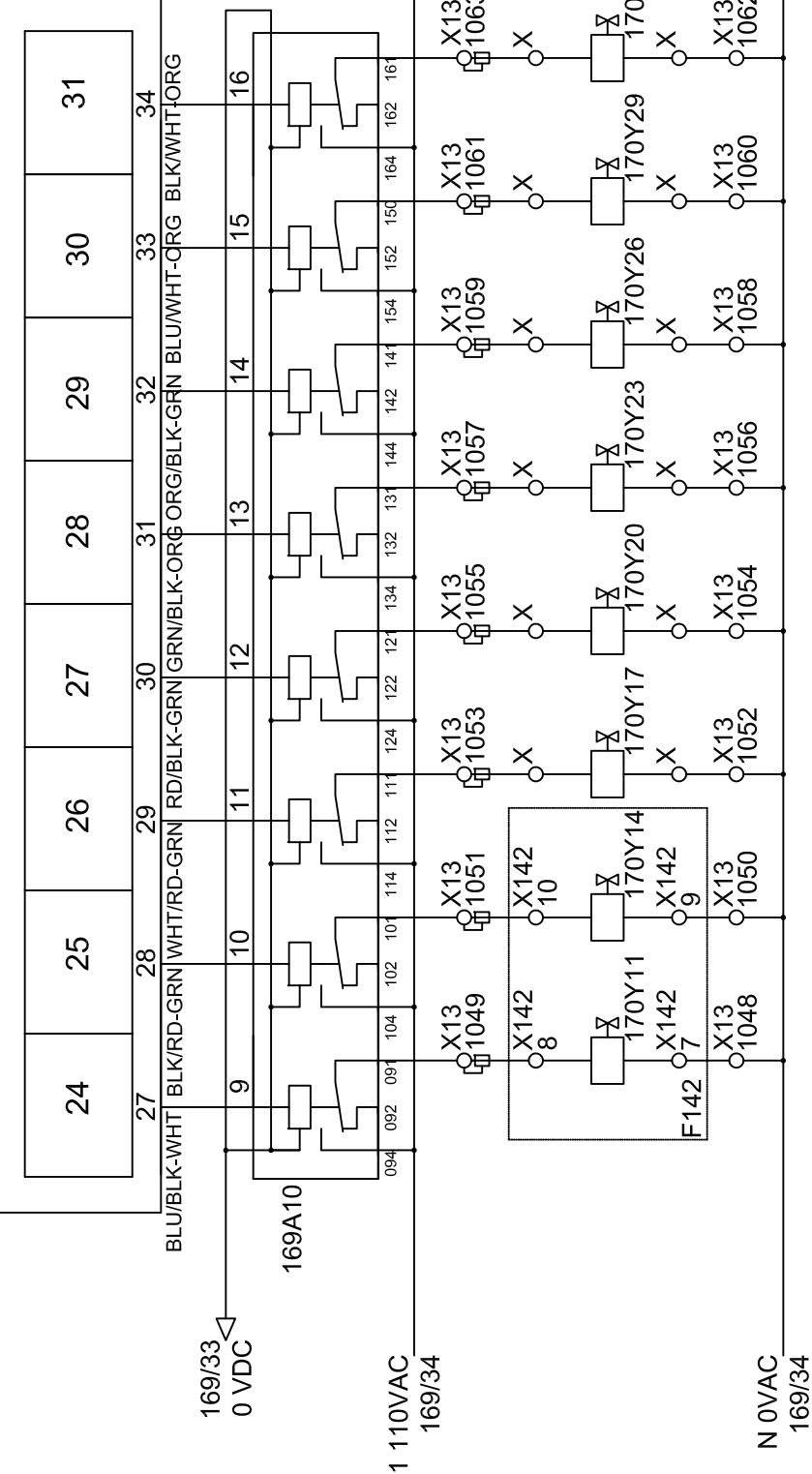


33 BI-C DIGITAL OUTPUT

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CLIPS CUBRIT	AIR ON CLIPS	MDO SV1435-15	ZONE 11 SV1511-03	MDO SV1510-06	ZONE 12 SV1435-16	ELECTROED 1 SV1020-07	COR. ROLL,6 SV1020-19	COR. PROX. SV1020-19	COR. ROLL,6 SV1020-16	COR. ELECTROED 2 SV1020-11	COR. ELECTROED 3 SV1020-11																						
XE04 FLAME TP WEB BREAK																																	
XE04 FLAME TP STOP																																	
XE04 FLAME TP STOP																																	

OF1_8 OF1_9 OF1_A OF1_B OF1_C OF1_D OF1_E OF1_F

RACK 2 / SLOT 6
Allen Bradley 1756-OB32



01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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DRAWN BY	JEFF LEE																																
CHECKED BY	VINCENT HUANG																																

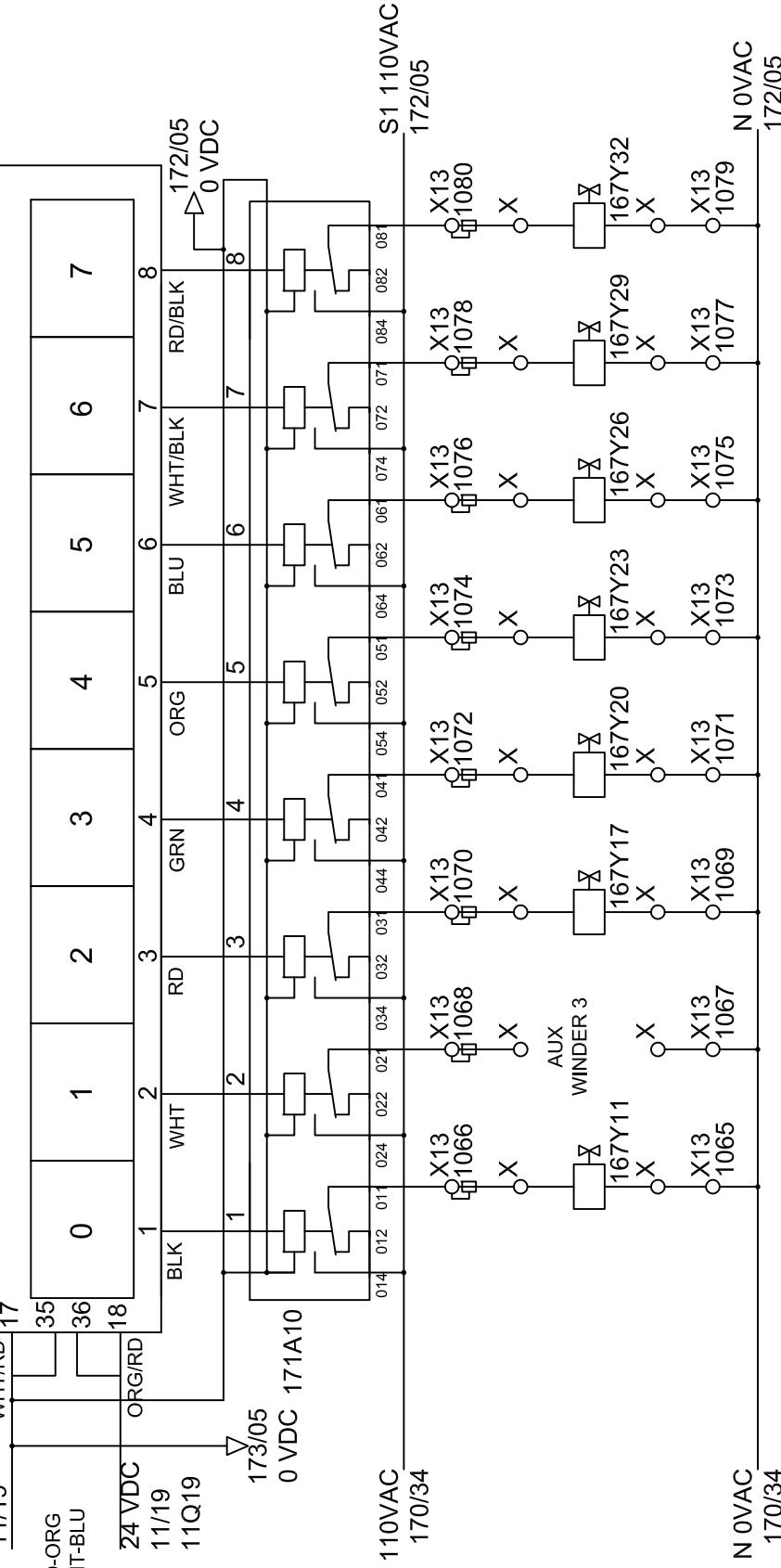
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COR. PROX. ROLL SV1020-15	AUX WINDER 3 ROLL 1 SV1840-01	OP. SPREADER ROLL 1 SV1840-2	DRIVE SPREADER ROLL 1 SV1840-3	OP. SPREADER ROLL 2 SV1840-4	DRIVE SPREADER ROLL 2 SV1840-05	OP. SPREADER ROLL 3 SV1840-06	DRIVE SPREADER ROLL 3 SV1840-06																										

OE2_0 OE2_1 OE2_2 OE2_3 OE2_4 OE2_5 OE2_6 OE2_7

RACK 2 / SLOT 7
Allen Bradley 1756-OB32

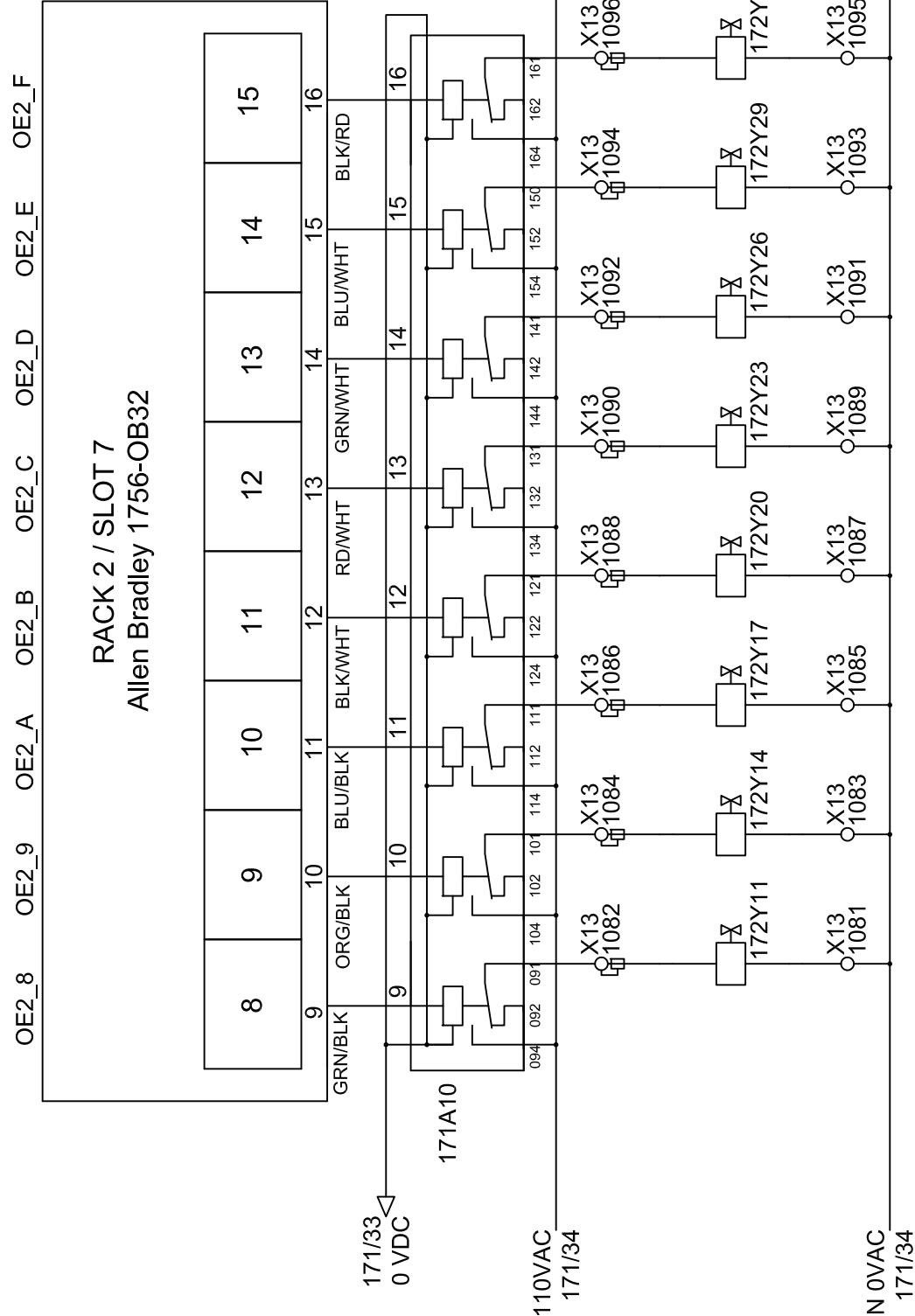


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INTEPLAST GROUP, Ltd. AMTOPP DIVI. MIE DEPT.																																	
DRAWN BY	JEFF LEE																																
CHECKED BY	VINCENT HUANG																																

1 UPGRADE TO AB Bryan Hong 12/08/2023 DRAWING NO. KF
REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: F13 DRAWING DESCRIPTION MATERIAL

Page # 171
Total

MATERIAL SCALe NONE UNIT MM



RACK 2 / SLOT 7
Allen Bradley 1756-OB32

OE2_E OE2_D OE2_C OE2_B OE2_A OE2_9 OE2_8

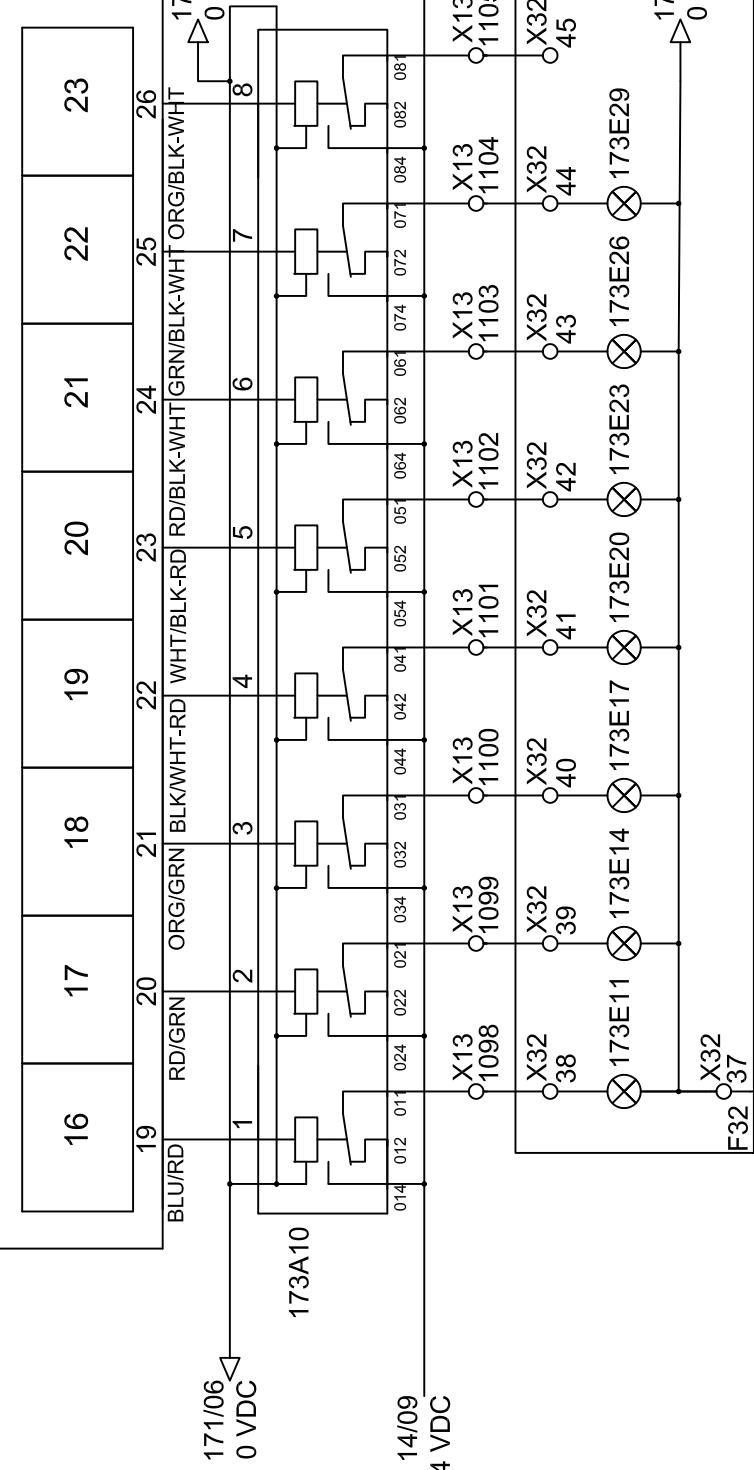
32 PI C DIGITAL OPTICAL

	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.
DRAWN BY	JEFF LEE
CHECKED BY	VINCENT HUANG

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EXHAUST HOOD	EDGE PINNING	AIR KNIFE POS	AIR BLOWER	AIR KNIFE	AIR BLOWER	C.R WATER REMOVAL	FILM WATER REMOVAL 1	FILM WATER REMOVAL 2	FREE	XE01	WATER BATH PUMP START																						

OF2_0 OF2_1 OF2_2 OF2_3 OF2_4 OF2_5 OF2_6 OF2_7

RACK 2 / SLOT 7
Allen Bradley 1756-OB32

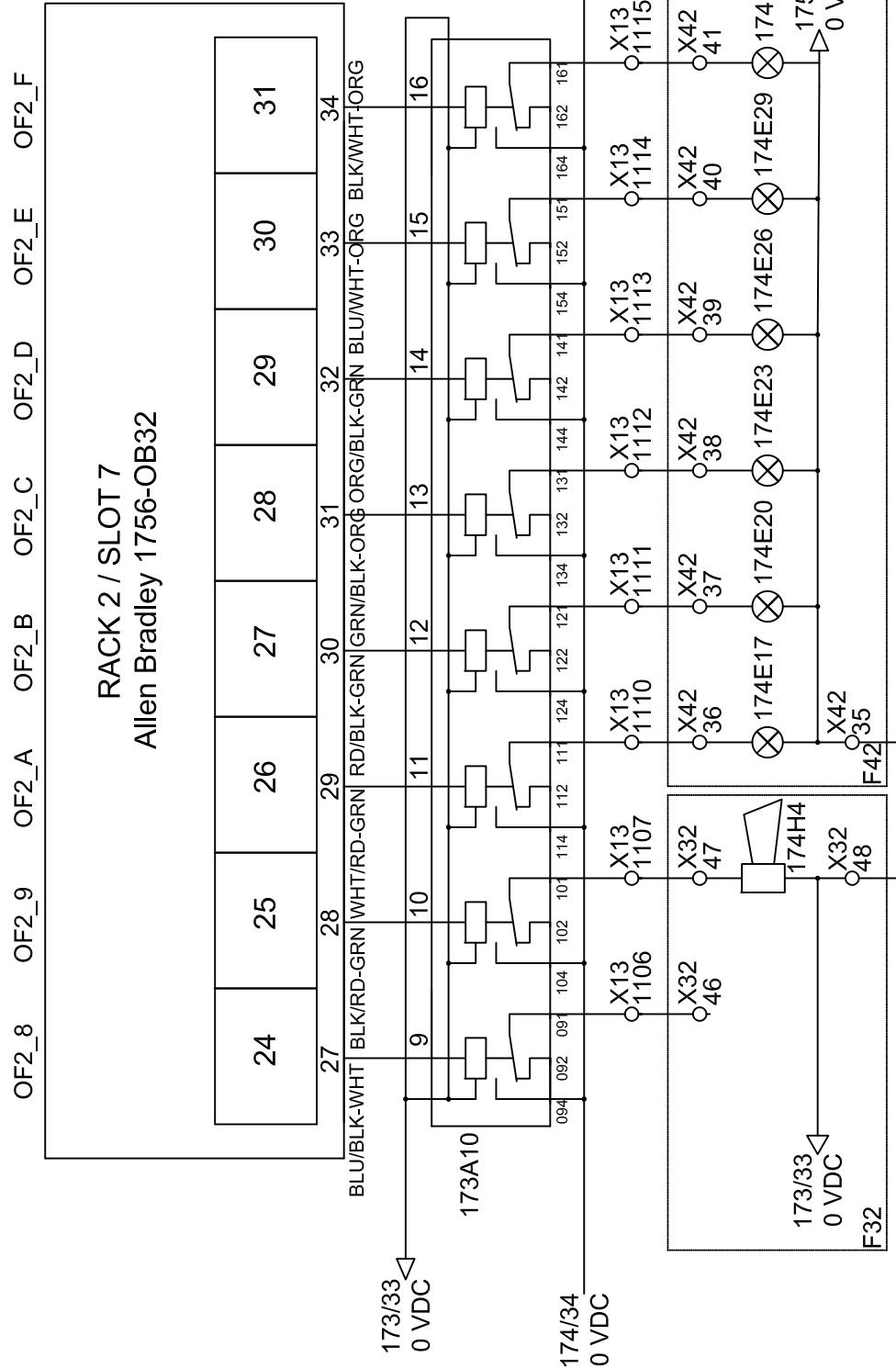


14/09
14Q9.2/24 VDC

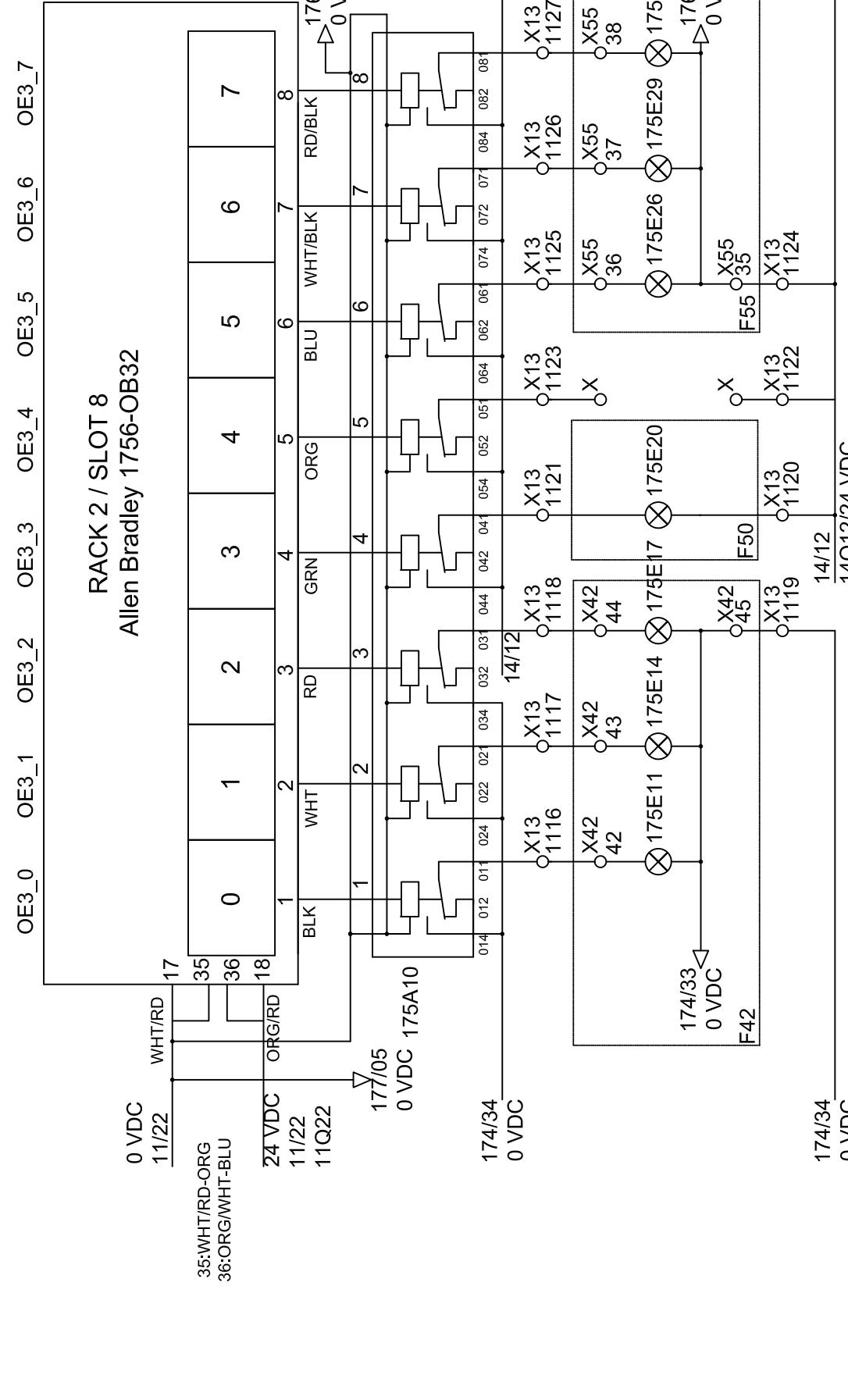
174/05
0 VDC

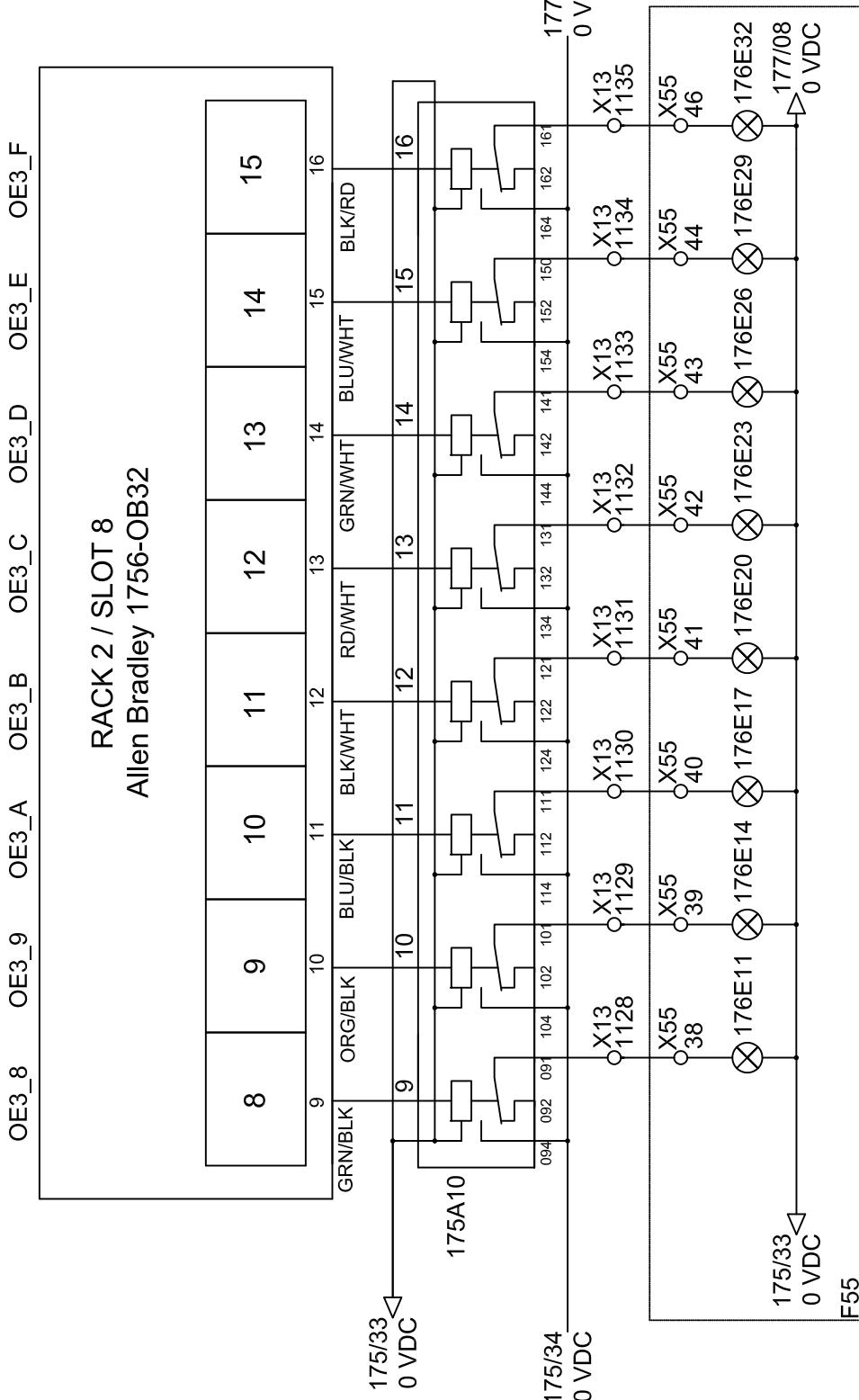
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01	02	03	04	05	06	07	08	09
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19	20	21	22	23	24	25	26	27
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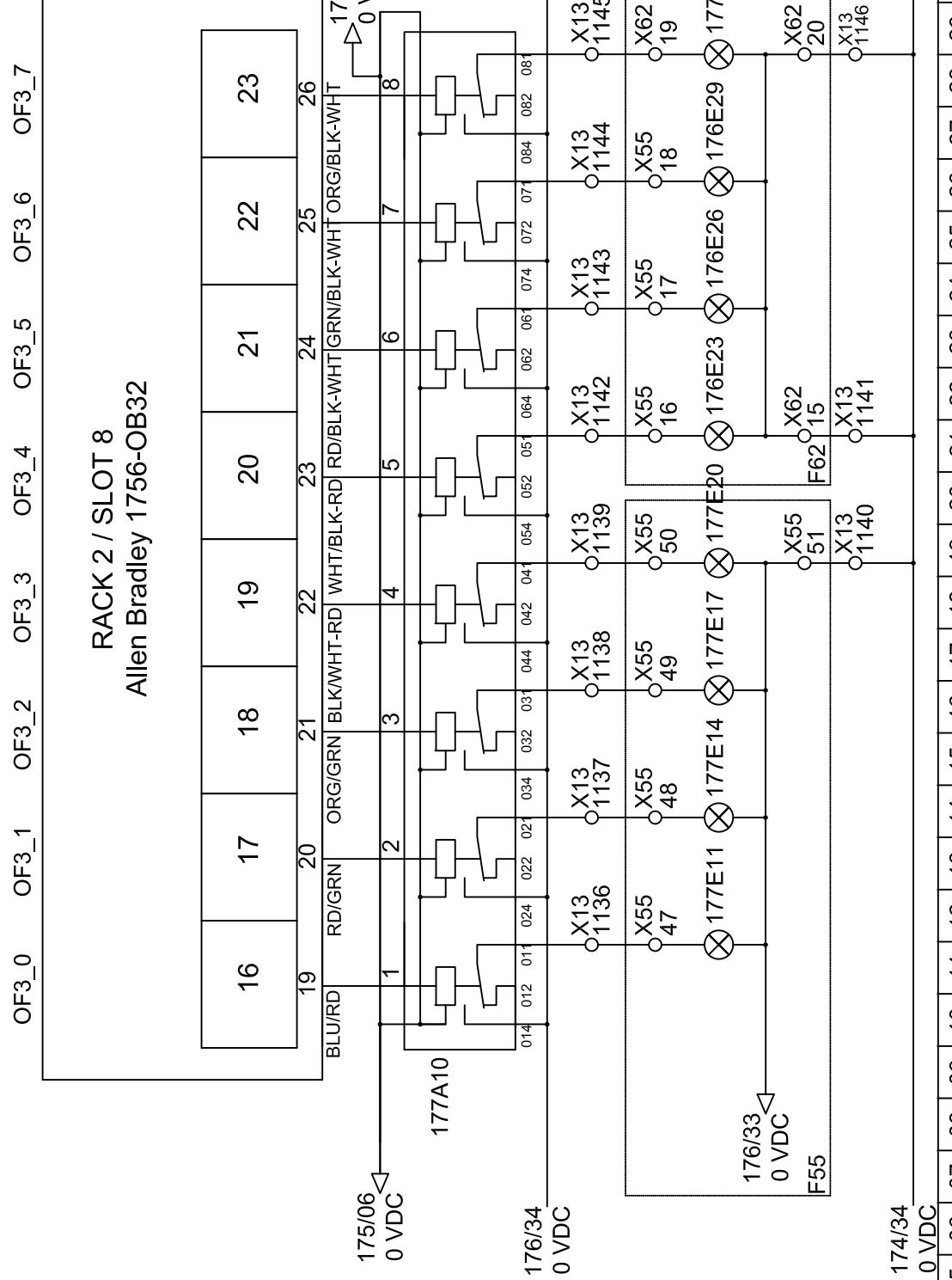
FOR
CHILL ROLL
MOVEMENT



RACK 2 / SLOT 7
Allen Bradley 1756-OB32

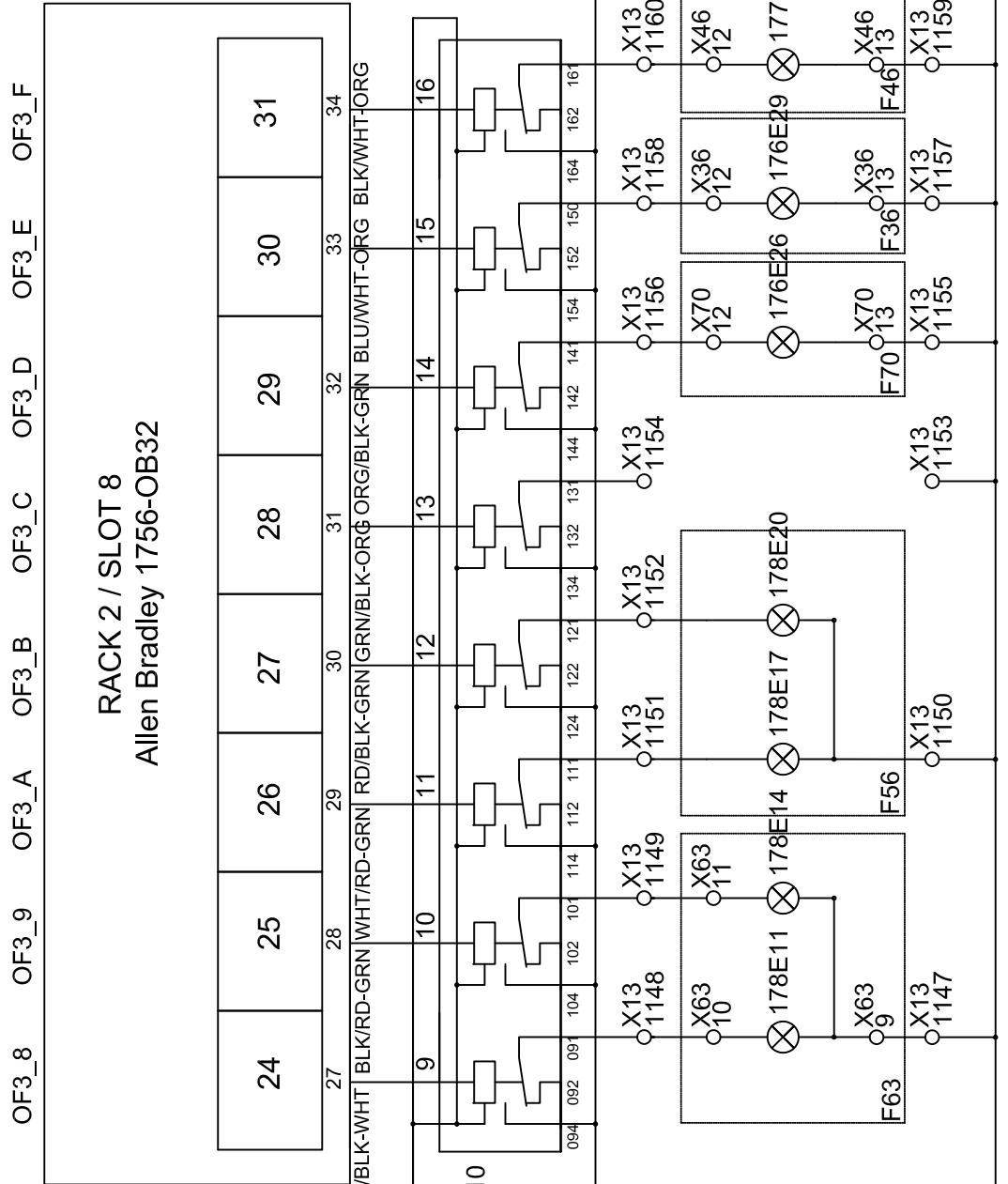






RACK 2 / SLOT 8
Allen Bradley 1756-OB32

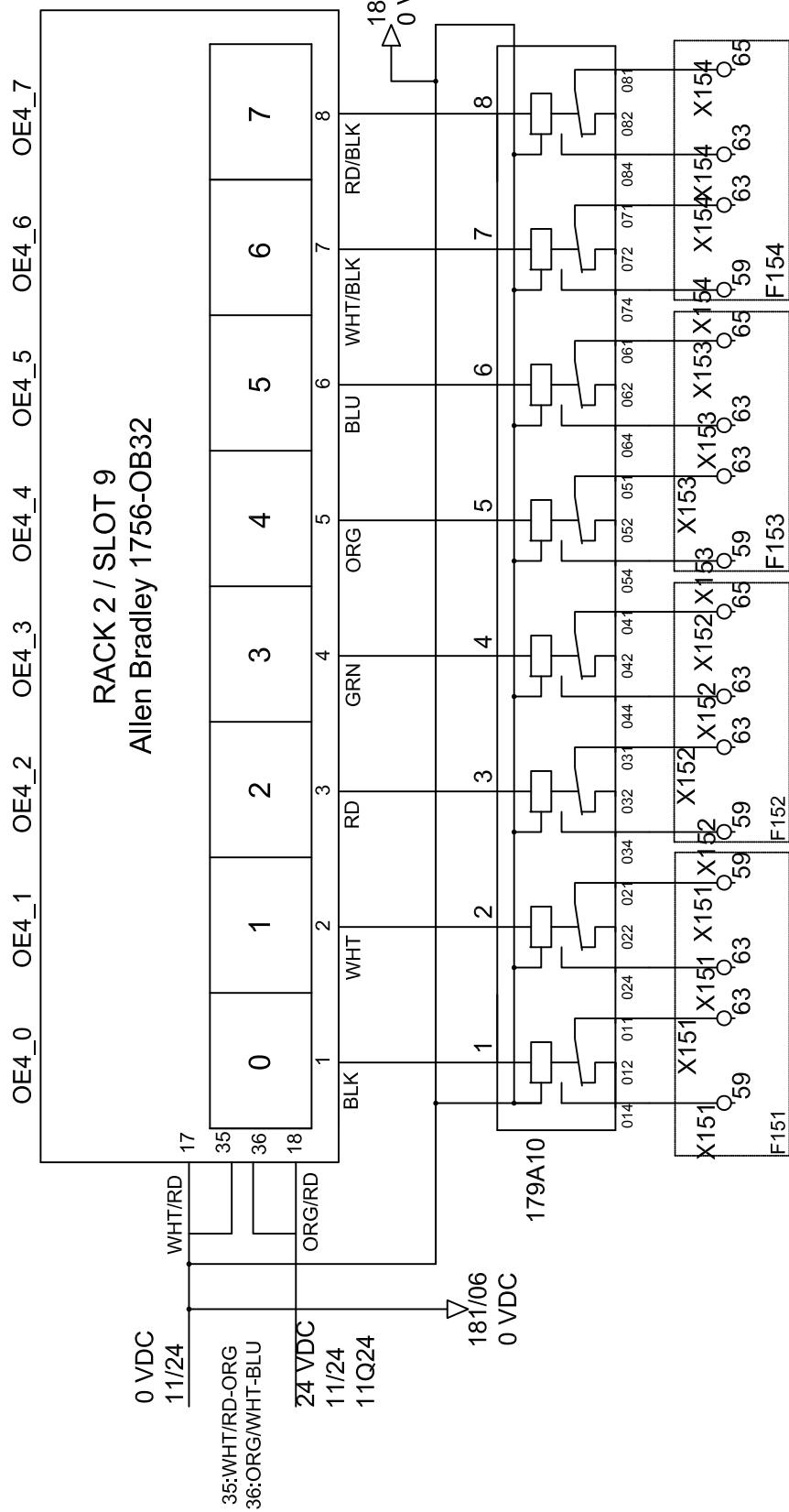
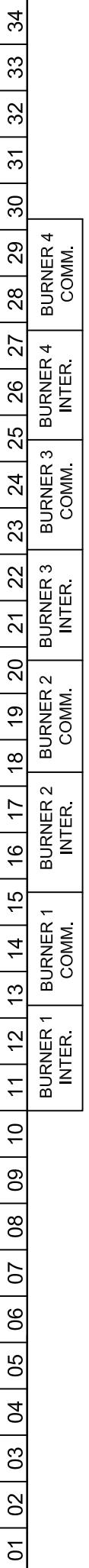
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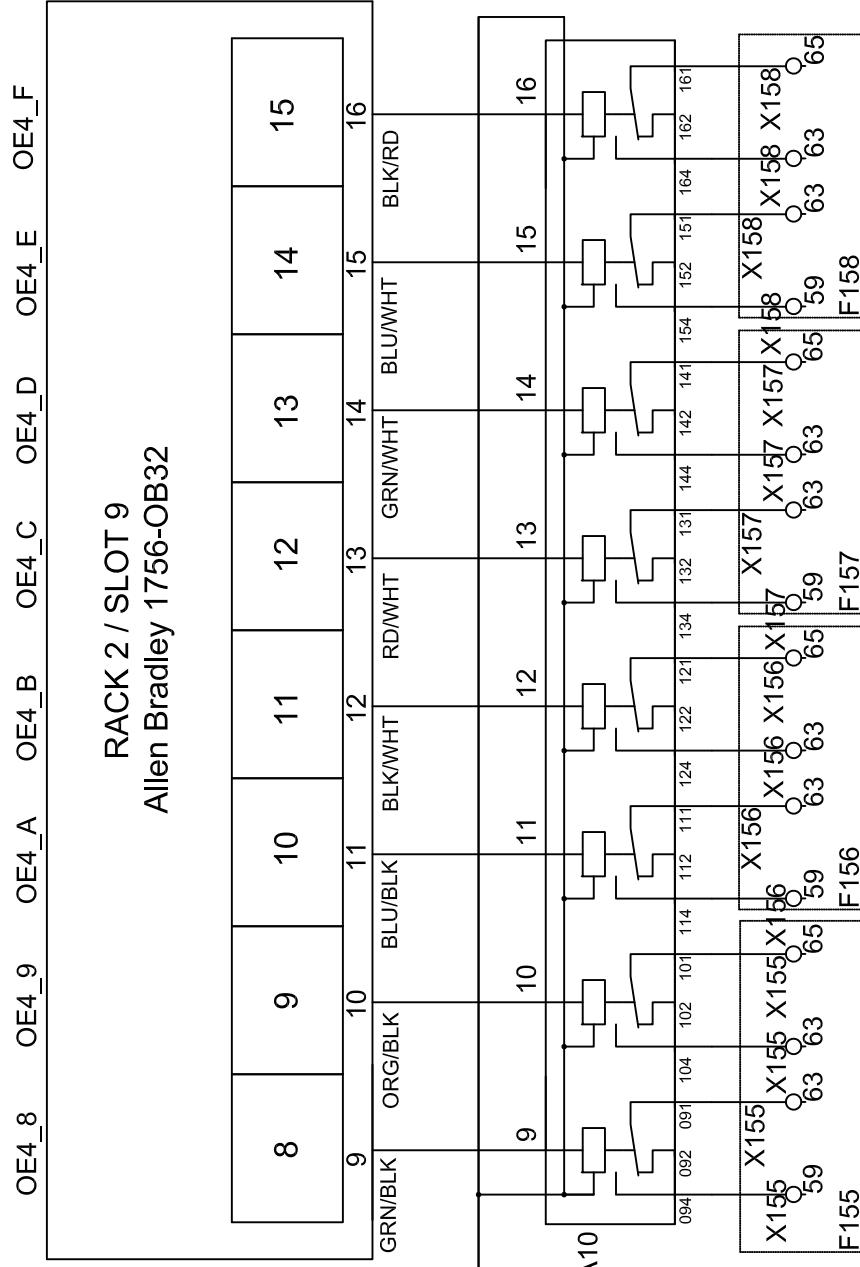
OE3 E OE3 E OE3 E

RACK 2 / SLOT 8
Allen Bradley 1756-OB32

32 DIGITAL IT



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BURNER 5 INTER.	BURNER 5 COMM.	BURNER 5	BURNER 6 COMM.	BURNER 6																													



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CHECKED BY	JEFF LEE																												Total				

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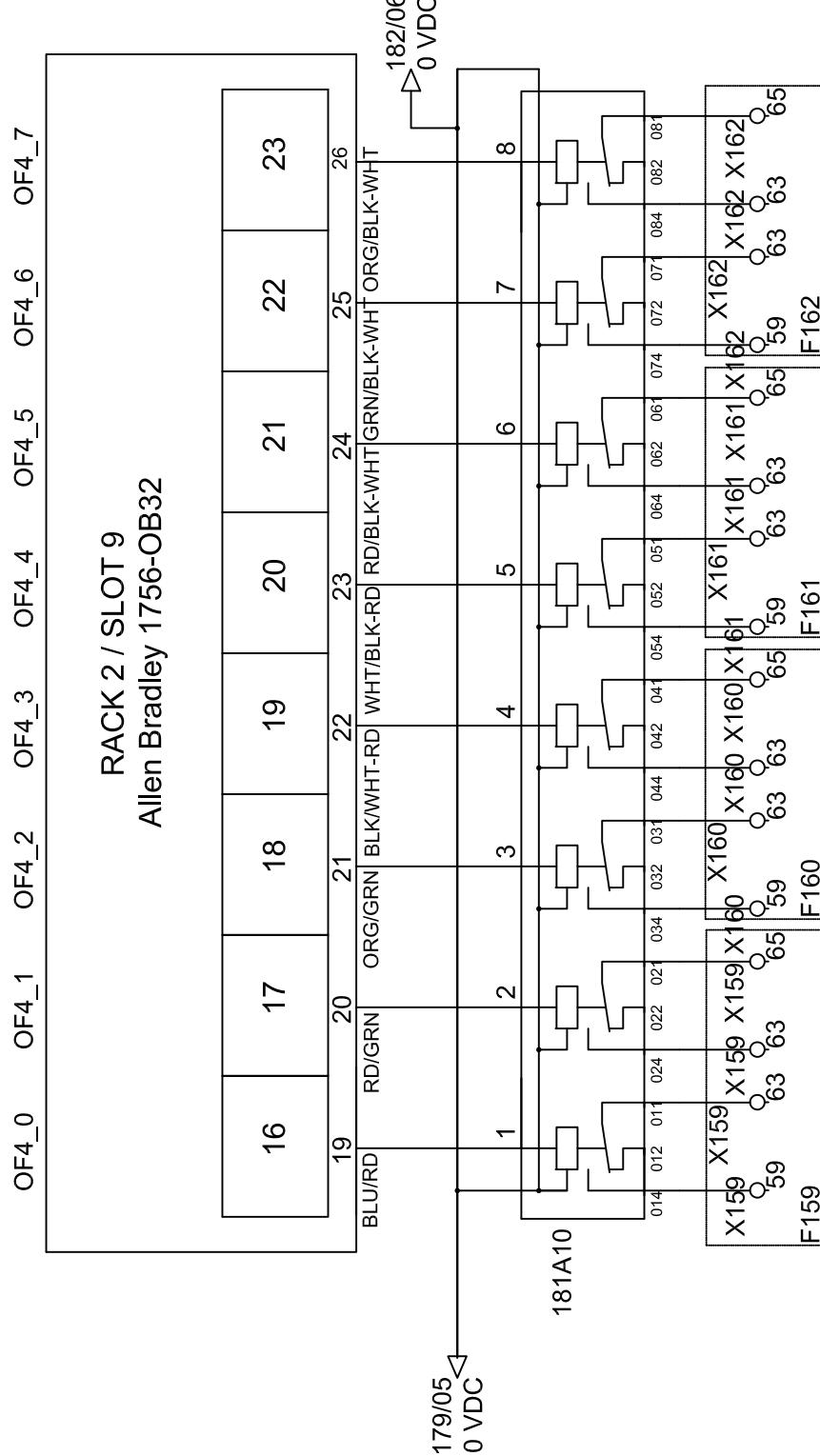
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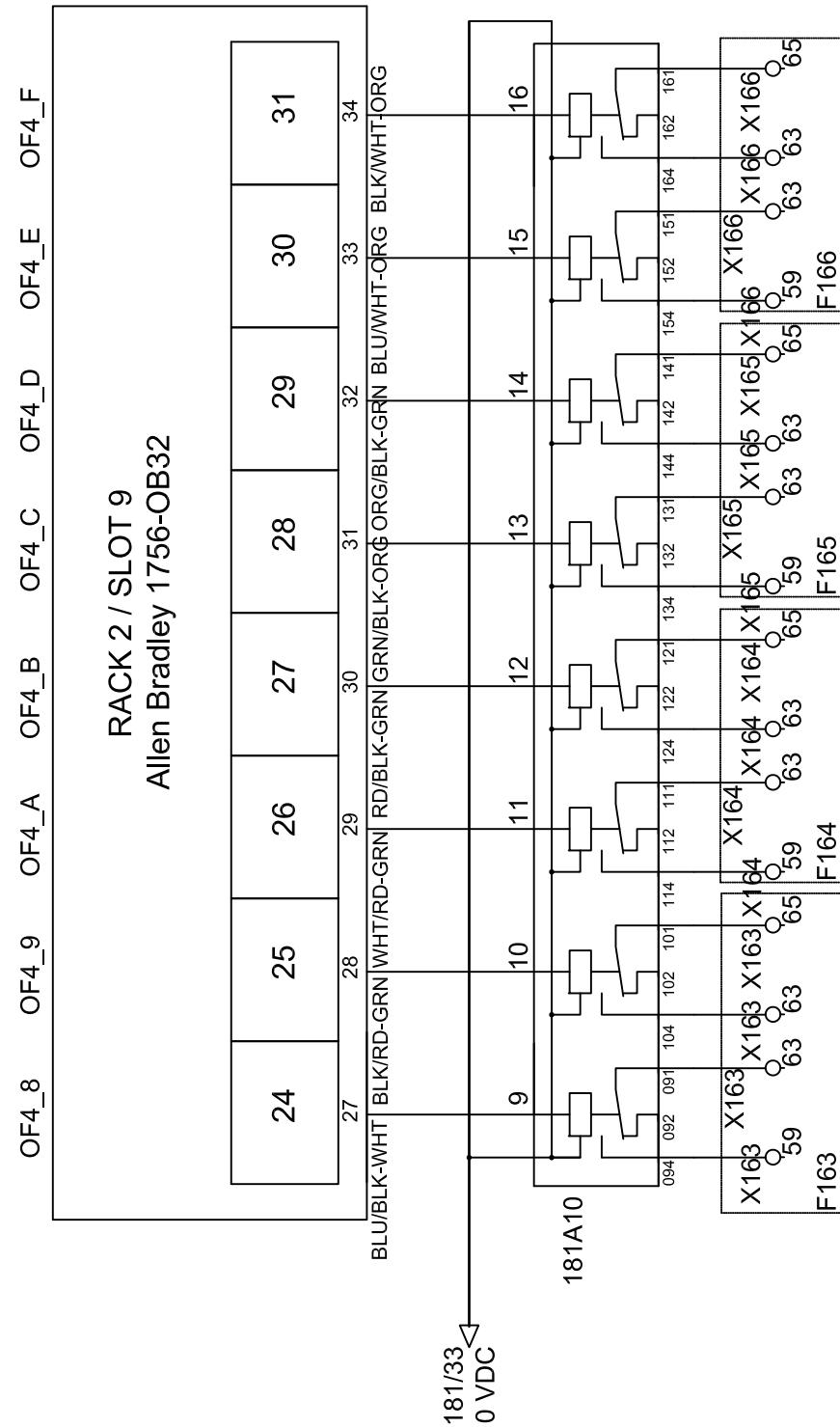
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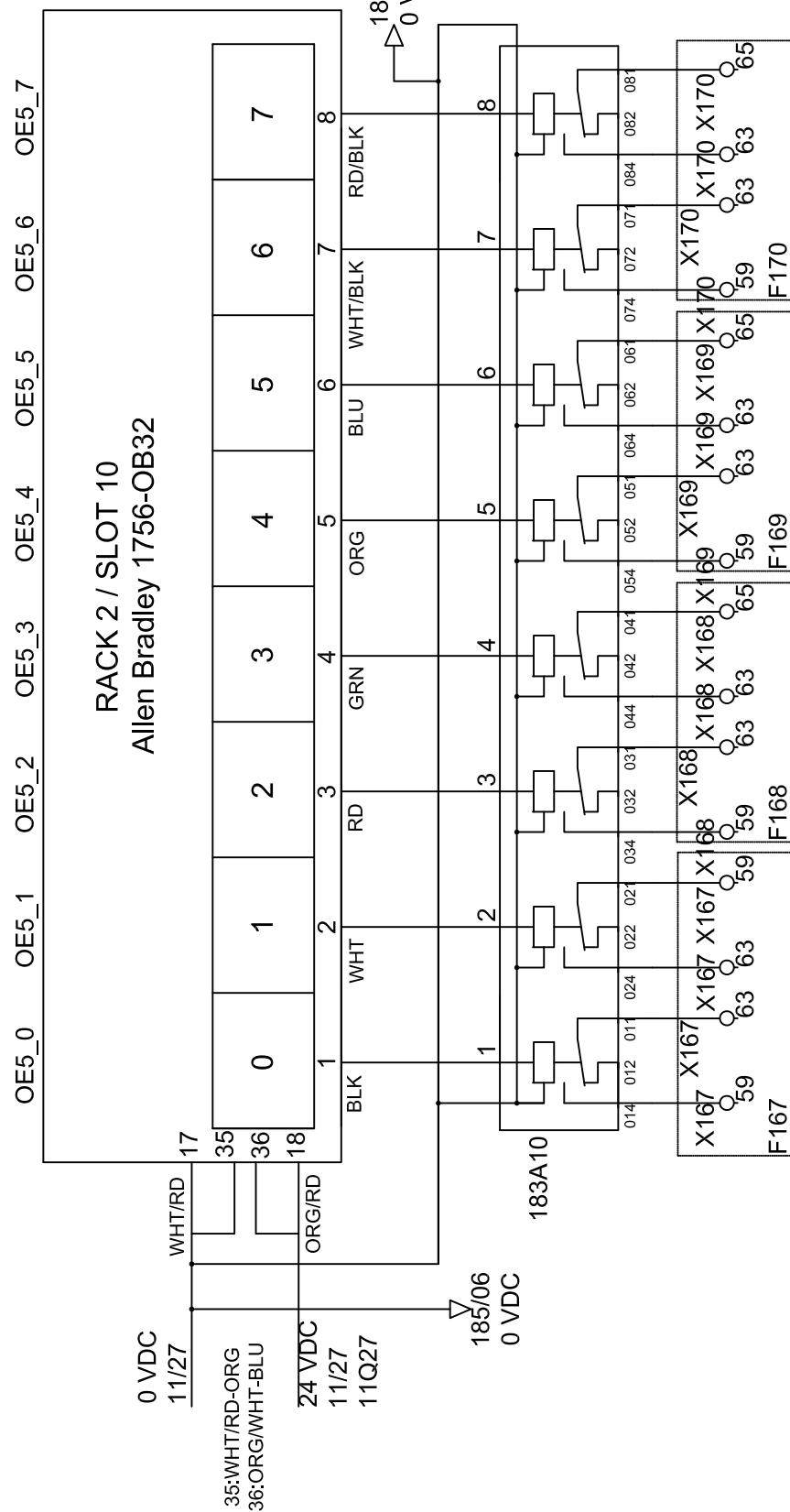
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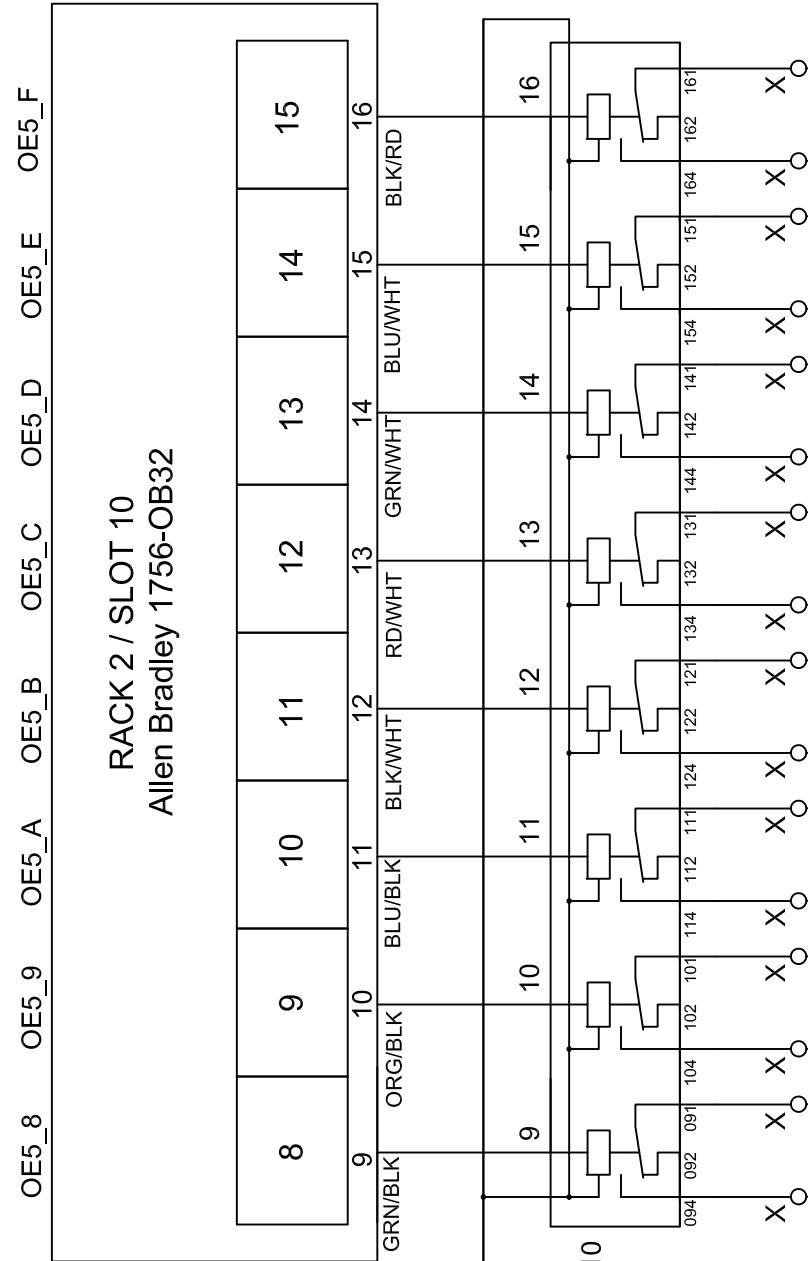
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								12/11/2023	Bryan Hong	KF F13	Page #	182																					
										Total																							
										MATERIAL																							

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BURNER 17 INTER.	BURNER 17 COMM.	BURNER 17 INTER.	BURNER 18 COMM.	BURNER 18 INTER.	BURNER 18 COMM.	BURNER 19 COMM.	BURNER 19 INTER.	BURNER 19 COMM.	BURNER 20 COMM.	BURNER 20 INTER.	BURNER 20 COMM.																						
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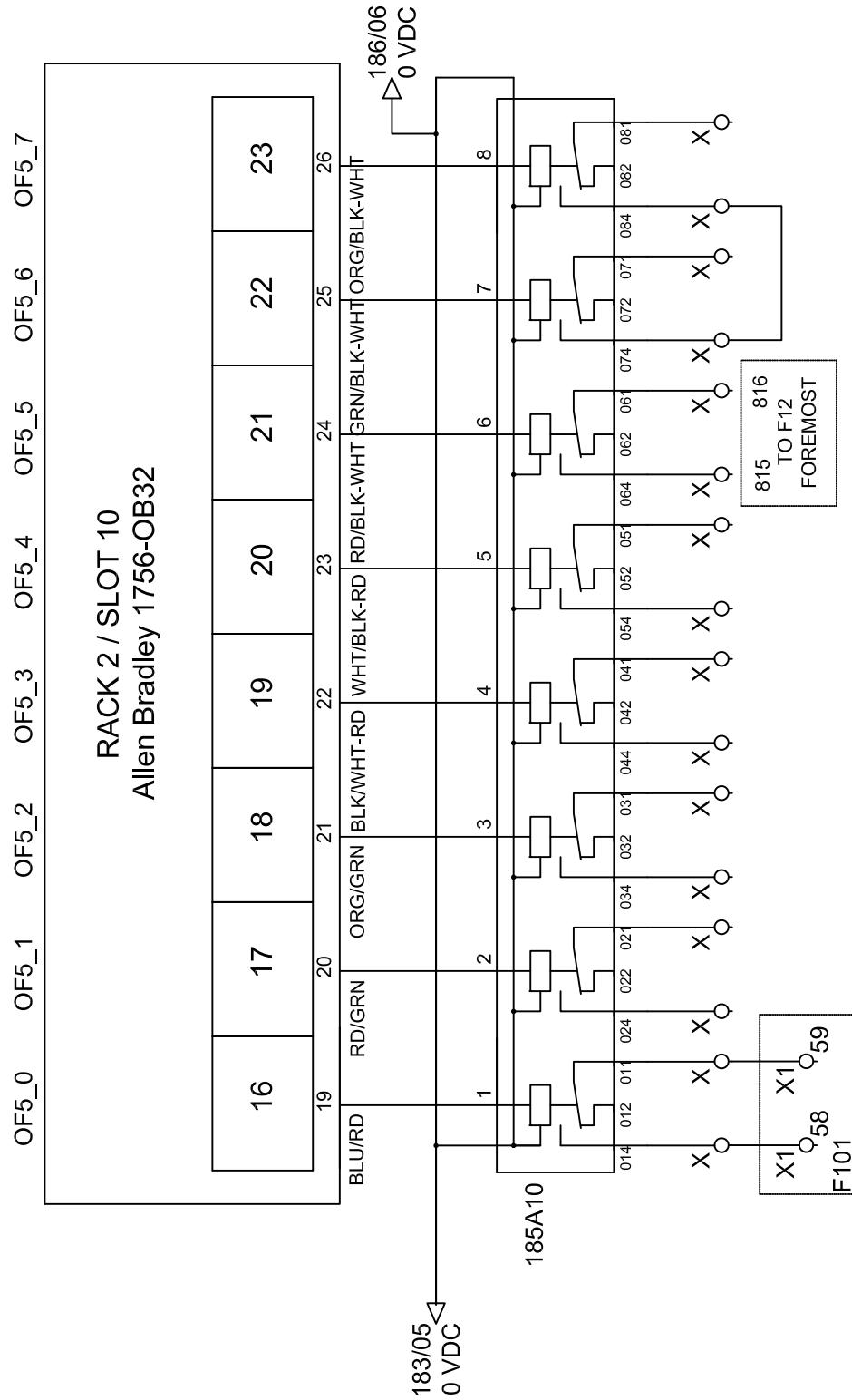


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CHECKED BY	JEFF LEE	1	UPGRADE TO AB	Eryan Hong	Total																												
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REV. DATE	03-03-2014	DRAWN DATE:	12/11/2023	SCALE	NONE																												

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P184 KNIFE GATE OPEN	P184 KNIFE GATE CLOSE	MDO WEB BREAK																															

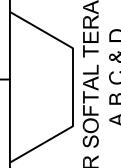


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P184 KNIFE GATE OPEN	P184 KNIFE GATE CLOSE	MDO WEB BREAK																															
DRAWN BY	JEFF LEE	INTEPLAST GROUP, Ltd. AMTOPP DIV. MIE DEPT.	2	LINE/F13 UPGRADE	Leo Lin	01/23/2024	DRAWING DESCRIPTION	KF	Page #	184																							
CHECKED BY	VINCENT HUANG		1	UPGRADE TO AB	Eryan Hong	12/11/2023	DRAWING NO.	F13	Total																								
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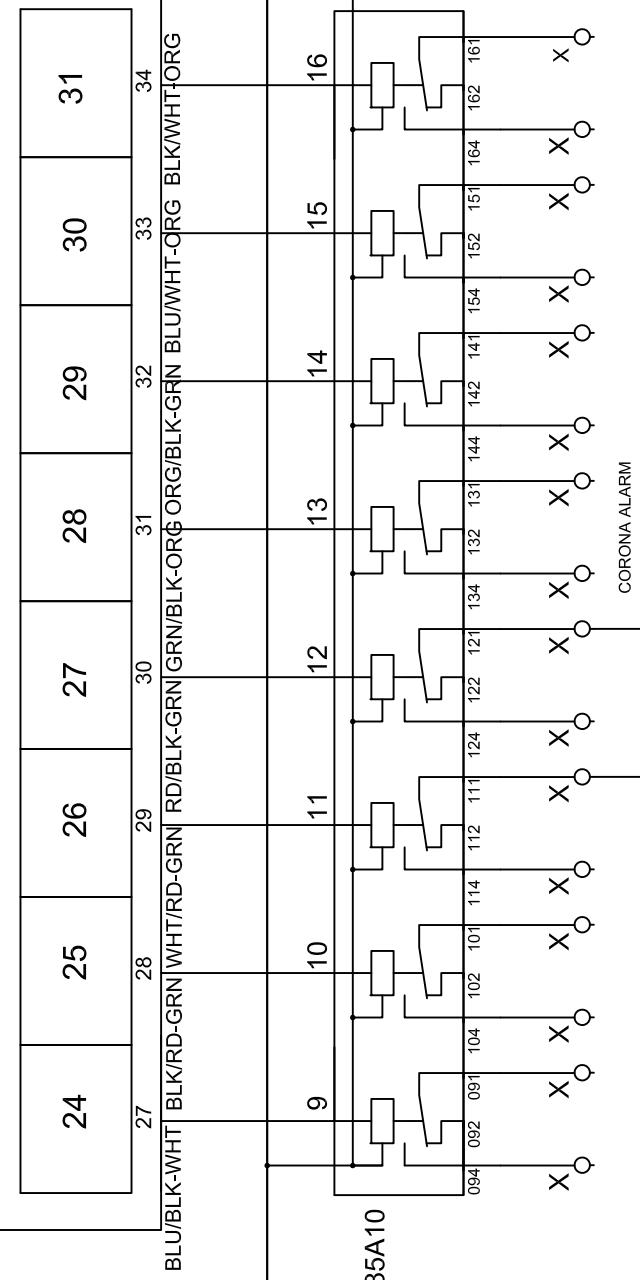
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														S.T. AB ENGAGED P186	S.T. AB RETRACT P186																		

FOR SOFTAL TERRATER
A,B,C & D



OF5_8	OF5_9	OF5_A	OF5_B	OF5_C	OF5_D	OF5_E	OF5_F
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RACK 2 / SLOT 10
Allen Bradley 1756-OB32



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INTEPLAST GROUP, Ltd.
AMTOPP DIVI, MIE DEPT.

DRAWN BY JEFF LEE

CHECKED BY VINCENT HUANG

32 P.L.C. DIGITAL OUTPUT

2	LINE 1 F13 UPGRADE	Leo Lin	01/23/2025	DRAWING DESCRIPTION	KF	Page #	186
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				03-03-2014		MM	

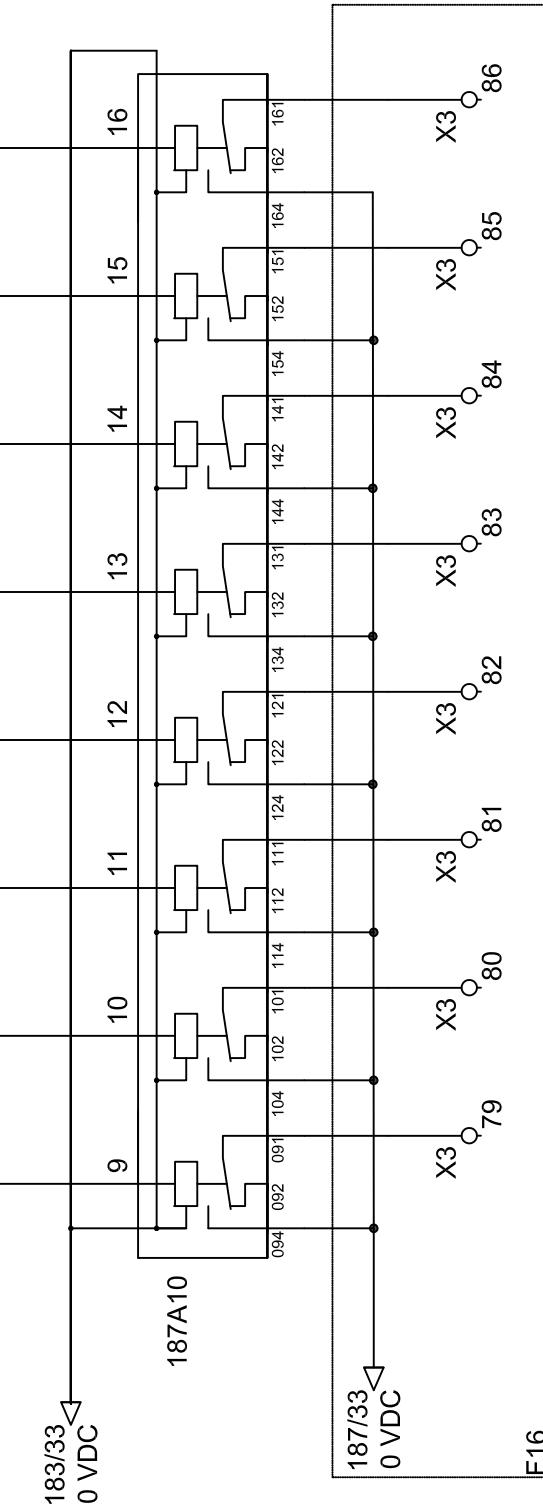
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AUX. 2 INTERLOCK	AUX. WINDER INTER	WEB BREAK MDO	WEB BREAK TDO	WEB BREAK PRS	MDO WARM ROLLS	TDO WARM																											

OE6_8 OE6_9 OE6_A OE6_B OE6_C OE6_D OE6_E OE6_F

RACK 2 / SLOT 11
Allen Bradley 1756-OB32

8	9	10	11	12	13	14	15	16
9	10	11	12	13	14	15	16	

GRN/BLK ORG/BLK BLU/BLK BLK/WHT RD/WHT GRN/WHT BLU/WHT BLK/RD



F16

REV. NO REV. DESCRIPTION REV. BY: DRAWN DATE:

03-03-2014

SCALE NONE

UNIT MM

INTEPLAST GROUP, Ltd. AMTOPP DIV., MIE DEPT.	KF F13	Page #	188
DRAWN BY	UPGRADE TO AB	Byan Hong	12/11/2023
JEFF LEE			
CHECKED BY	VINCENT HUANG	DRAWING NO.	MATERIAL

C.R COOLING C.R COOLING
INTER C1340 C1340
C.R COOLING C.R COOLING
INTER C1340 C1340
WATER BATH
INTER C1350 C1350
WATER BATH
COMM. C1350 C1350
START GAS
BOILER SKID COMM.
C1430 C1430
GAS BOILER
SKID COMM.
C1430 C1430
WATER BATH
LEVEL SV'1350-03
WEB BREAK
FOR NESUREX

